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**Lamb et al.**

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(54) **NON-SETTLING HYDROLYZED WHEY PERMEATE CONCENTRATE AND RELATED METHODS AND NUTRITIONAL COMPOSITIONS**

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(51) **Int. Cl.**

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**A23C 17/00** (2006.01)  
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**A23C 1/00** (2006.01)  
**A23C 9/00** (2006.01)  
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**A23C 21/02** (2006.01)  
**A23C 1/12** (2006.01)

(52) **U.S. Cl.**

CPC ..... **A23C 21/023** (2013.01); **A23C 1/12** (2013.01); **A23K 10/28** (2016.05); **A23K 20/147** (2016.05); **A23K 50/10** (2016.05); **A23C 9/1209** (2013.01); **A23C 9/1544** (2013.01); **A23C 21/02** (2013.01); **A23C 21/026** (2013.01); **Y02P 60/875** (2015.11)

(58) **Field of Classification Search**

USPC ..... 426/573  
See application file for complete search history.

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*Primary Examiner* — Erik Kashnikov

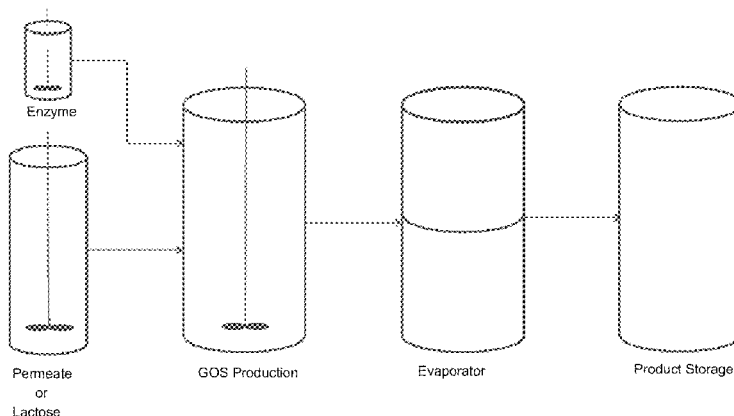
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(57) **ABSTRACT**

The present invention includes a method of producing non-settling hydrolyzed whey permeate with an enzyme, the non-settling hydrolyzed whey permeate concentrate, and nutritive additives and foods made therefrom.

**8 Claims, 42 Drawing Sheets**



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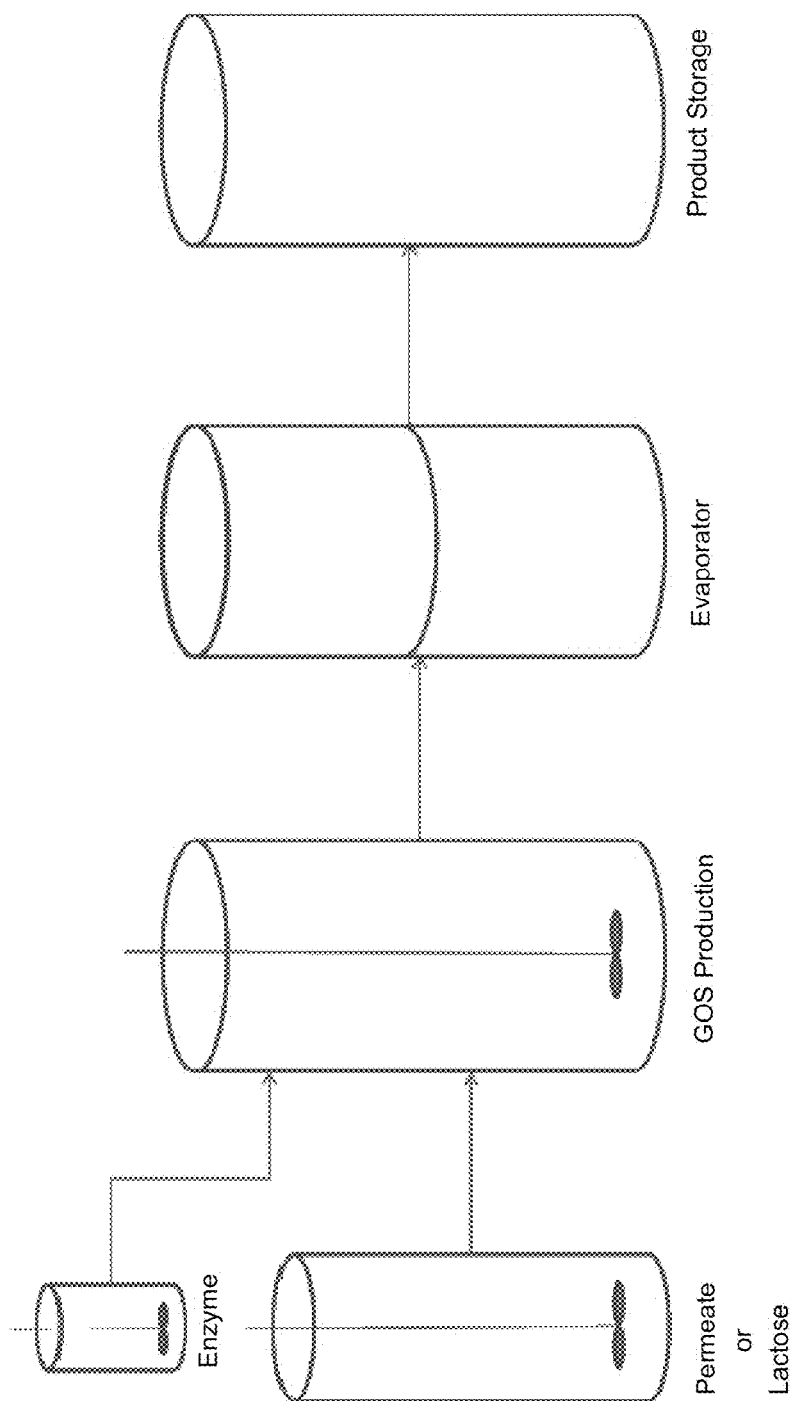


Figure 1

LAC-090209A-0.5% Novo, pH6.5

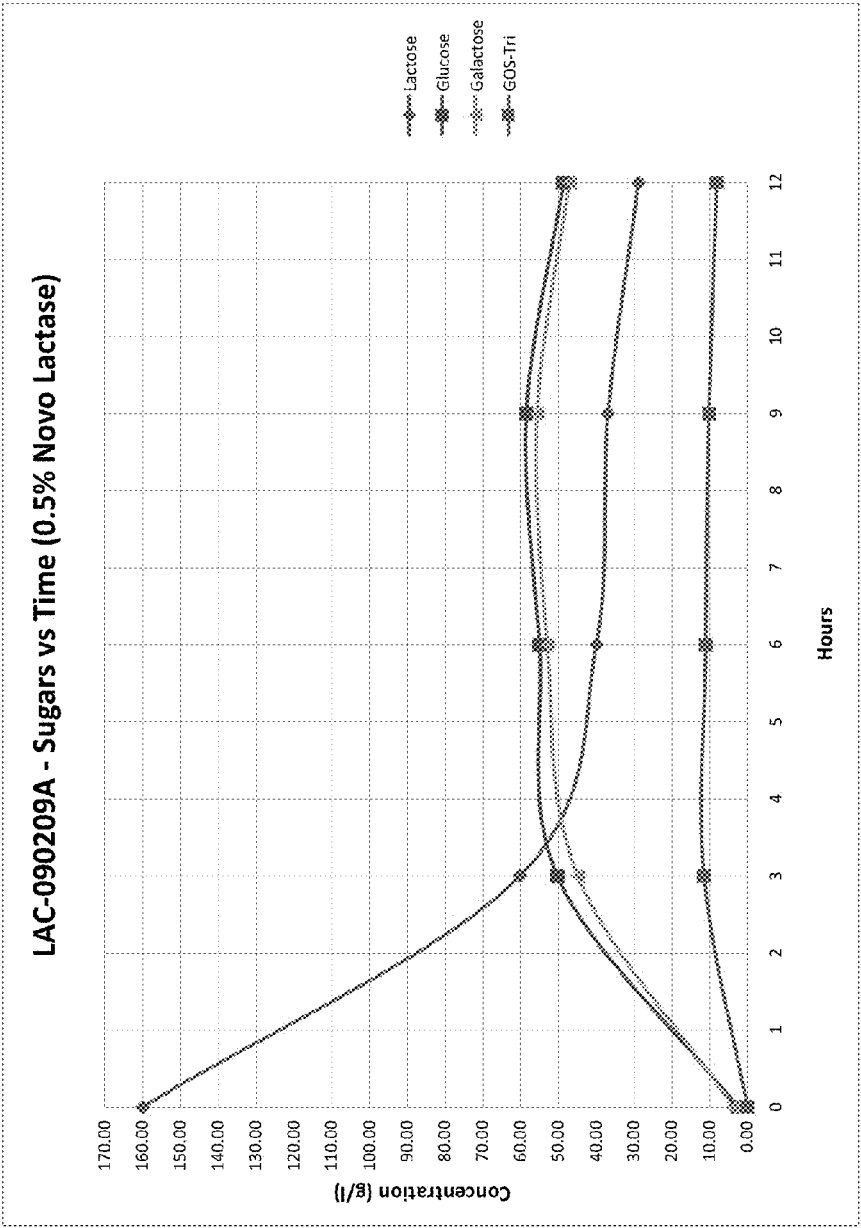


Figure 2

# LAC-090209B-0.2% Novo, pH6.5

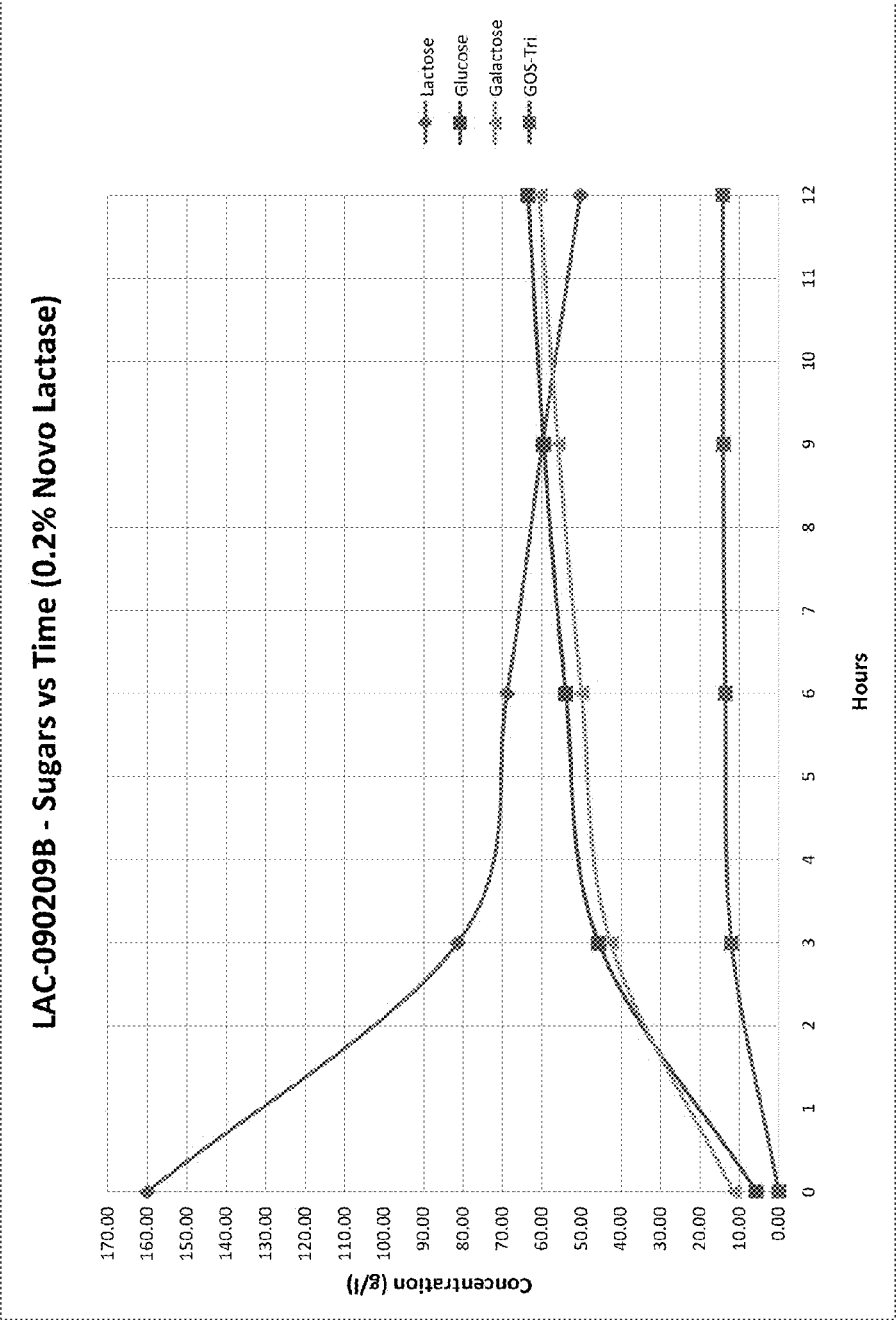


Figure 3

# LAC-090209C-0.1% Novo, pH6.5

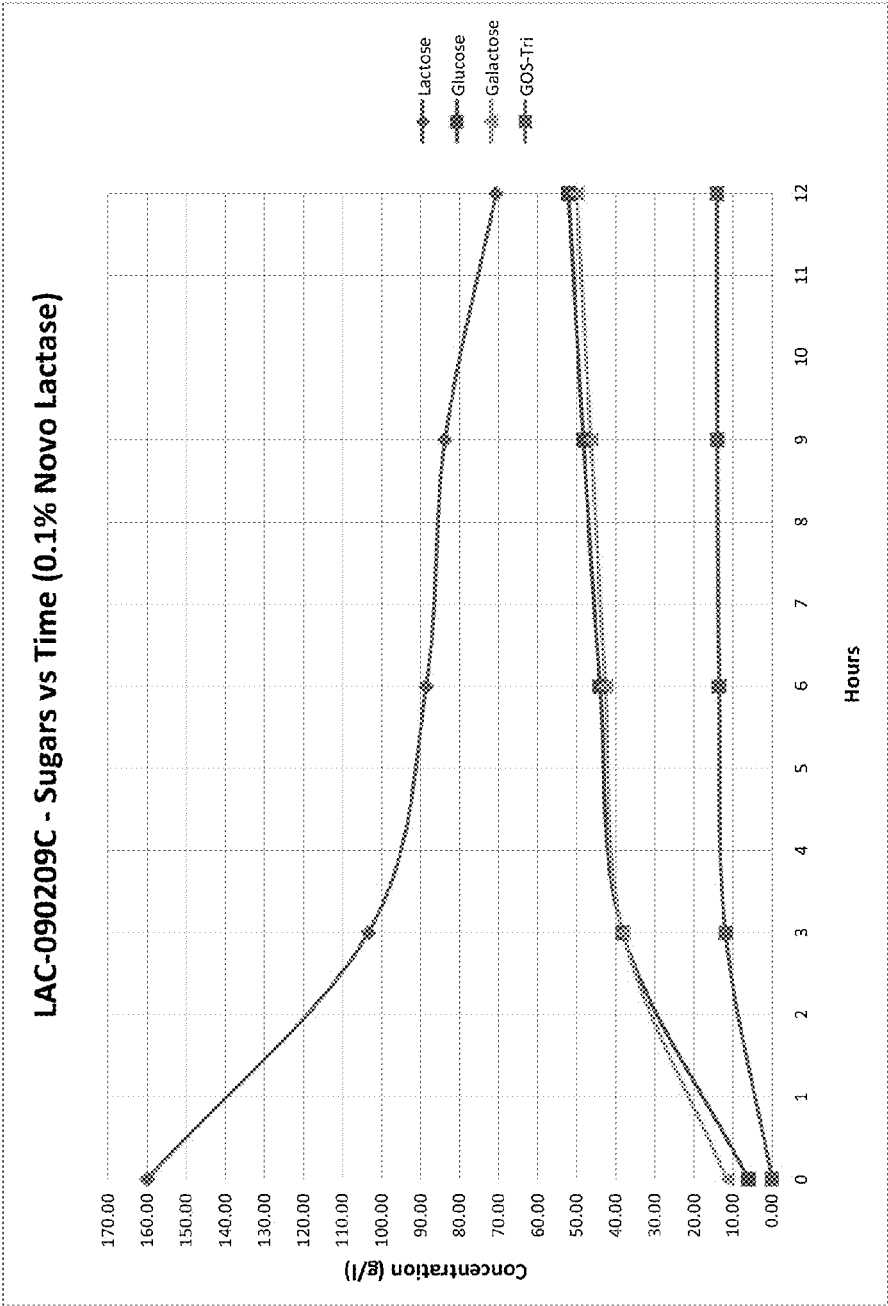


Figure 4

# LAC-090209-0.5,0.2,0.1% Novo, pH6.5

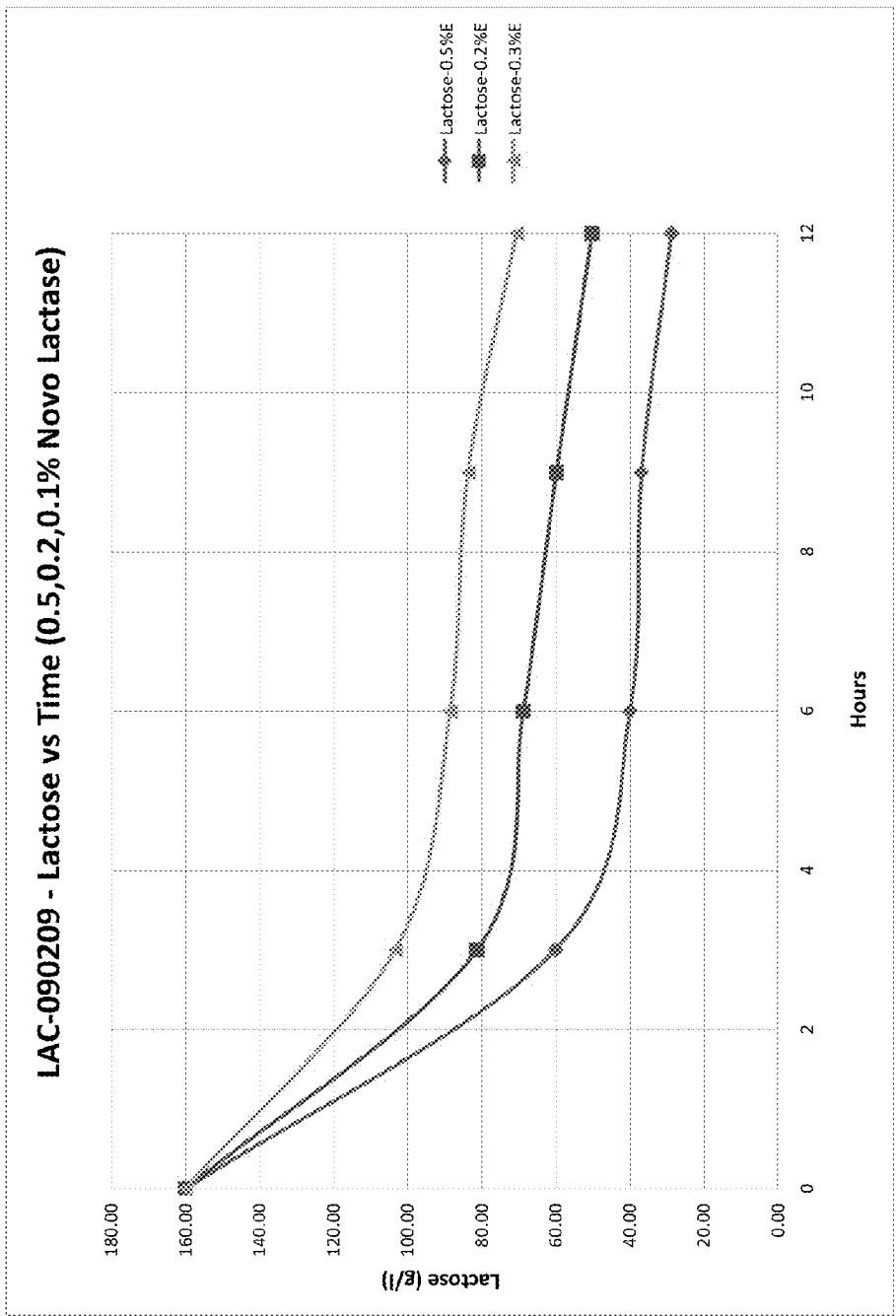


Figure 5

LAC-090209-0.5,0.2,0.1% Novo, pH6.5

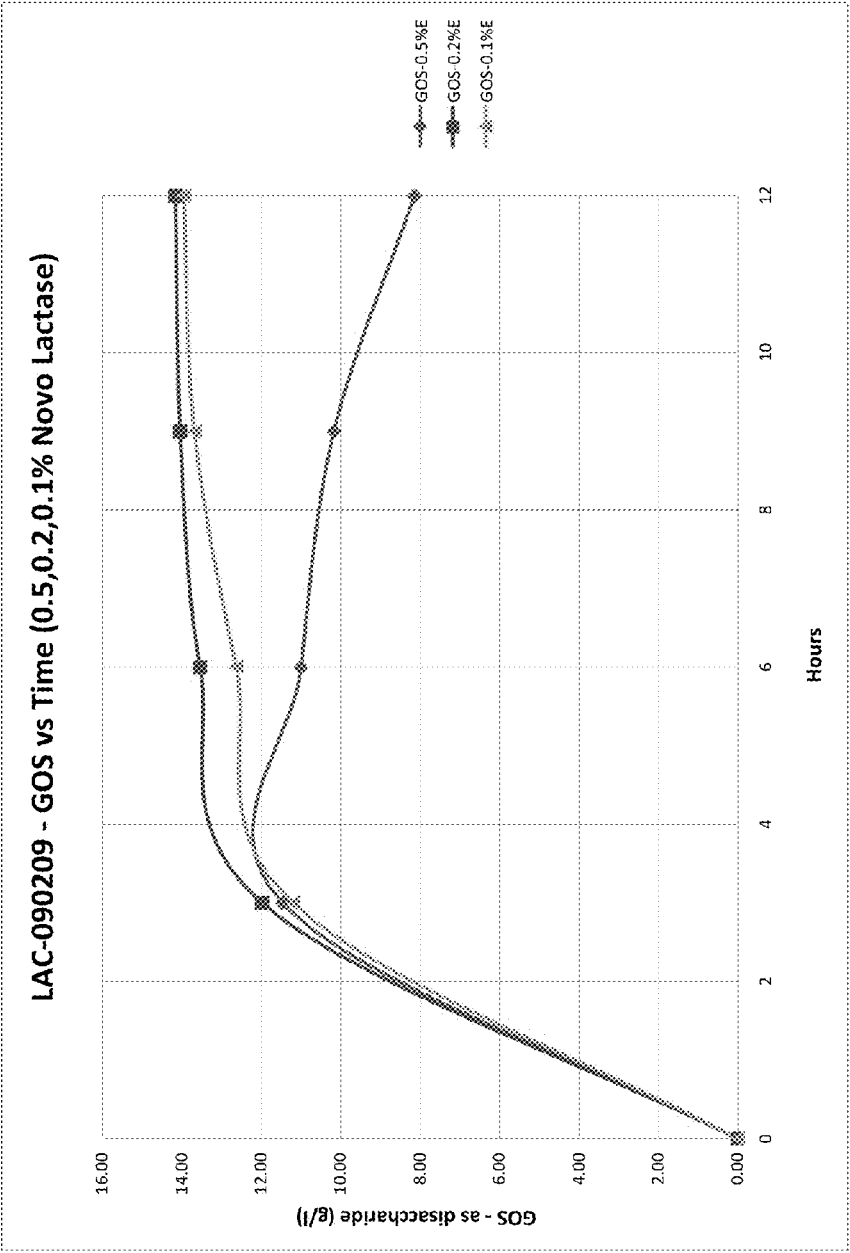
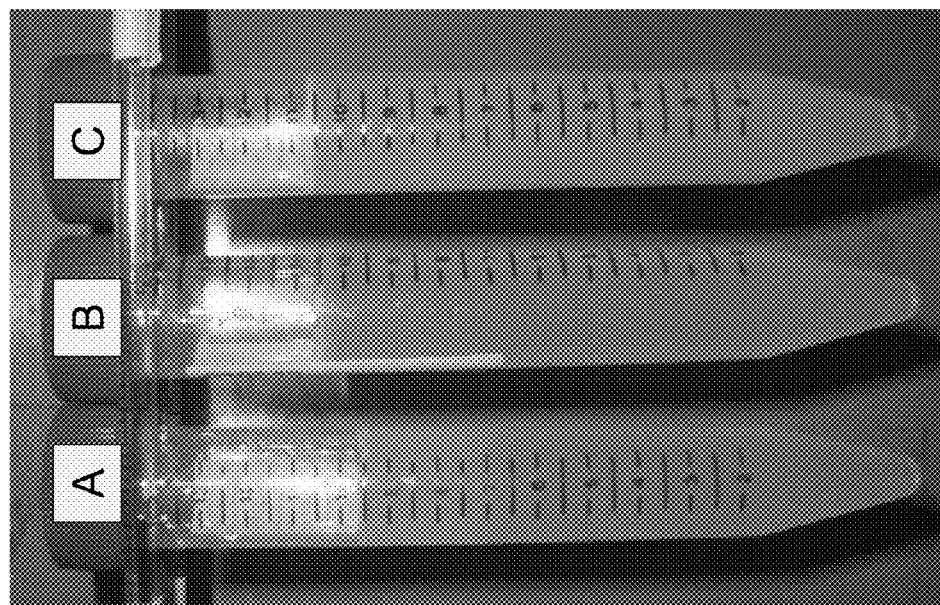


Figure 6





# LAC-090209 A, B, C

pH 6.5 – 12 hr Hydrol – 80% Solids

- A. 0.5 % Novo Lactase
- B. 0.2 % Novo Lactase
- C. 0.1 % Novo Lactase

Figure 7

# LAC Plant Trials 1 & 2 HPLC Data

Sample	Plant Trial #1	Plant Trial #2
Lactose Source	20% Permeate	20% Permeate
Enzyme Level	0.50%	0.50%
Hrs	Concentrate	Concentrate
Lactose (+GOS Disaccharide) (gm/l)	1st rep	75.18
	2nd rep	75.21
	AVG	75.19
Glucose (gm/l)	1st rep	44.11
	2nd rep	44.14
	AVG	44.13
Galactose (gm/l)	1st rep	46.22
	2nd rep	46.24
	AVG	46.23
GOS-Trisaccharide (gm/l)	1st rep	13.77
	2nd rep	13.77
	AVG	13.77
%Lactose Hydrolyzed (based on Glucose-160 start)	(molar)	52.40%

Figure 8

3/16/2009

Lactose hydrolysis	(17-20% Permeate pH 6.5 0.5% lactase at 95 F for 12 hours - Evap)			
Experiment Number.	To develop plant-scale process for 75% (solids) hydrolysis as molasses replacement			
	08-003, #5			
	pasteurize the permeate			
	hydrolyze the 17-20% permeate with lactase at pH 6.5, 95 F for 12+ hours			
	evaporate the hydrolysis to 70-80% as finished products through MVR and TVR			
	35,500 lbs Permeate with 17-20% solids (using 17-20% permeate off the R/O)			
	32.5 lbs Lactozyme			
	Pasteurized 17-20% Permeate - 95 F, pH 6.5 with 0.5% Lactozyme 3000L (1 dosing) for 12+ hrs, then evaporation to 75% solids	lbs	pH	Time
	Pasteurize the permeate - heat up to 150 F/1 hr (160 F/20-30 min) and cold down to 95 F in a A tank			
	CIP and sanitize C12.			
	Transfer the pasteurized permeate into C12			10:30 AM
	Adjust pH to 6.5 with 50% caustic	127.6	6.51	
	Add 32.5 lbs of Lactozyme 3000L to 32.5 lbs of water and mix well. Add to C12.			10:50 AM
	Check pH and adjust pH if necessary		6.36	2:50 PM
	Check pH and adjust pH if necessary		6.33	4:30 PM
	Check pH and adjust pH if necessary		6.26	10:50 PM
	Finish the hydrolysis at 95 F for 12 hrs if pH <5.9, if pH >5.9 hydrolyze for another 4 hours			evaporated at 4:00 AM
	Evaporate to 70-80% Solids through MVR and TVR			75%
	Fill the 70-80% hydrolysis in totes at 140 F			

Figure 9

Experiment Number: Notebook Reference:	LAC-090209	(20%Perm-0.5,0.2,0.1% Lactozyme3000-35C,pH6.5,12hrs-HPLC,pH4,Evap)
Objective:	To determine the effect of hydrolysis of 20% Perm with Novo Lactozyme3000 at 0.5, 0.2 and 0.1% on Permeate Solids, at 35C, pH6.5 for 12hrs, followed by adjusting pH to 4.0 with conc HCl, followed by evaporation to 60 & 80% solids.	
Materials:		
A	1700.0 gm Water	
	425.0 gm Dried Permeate	
	2.13 gm Novo Lactozyme 3000L	
B	1700.0 gm Water	
	425.0 gm Dried Permeate	
	0.85 gm DFL5000	
C	1700.0 gm Water	
	425.0 gm Dried Permeate	
	0.43 gm DFL5000	
50	Evap to 50% Solids	$(20\%)(125)=(60\%)X$
	Evap 125 gm to 140 gm	$X=(20)(125)/(50)= 50$
60	Evap to 60% Solids	$(20\%)(150.38)=(60\%)X$
	Evap 150.38 gm to 133 gm	$X=(20)(150.38)/(60)= 50$
70	Evap to 70% Solids	$(20\%)(174.63)=(70\%)X$
	Evap 174.63 gm to 136 gm	$X=(20)(174.63)/(70)= 50$
80	Evap to 80% Solids	$(20\%)(200)=(80\%)X$
	Evap 200 gm to 50 gm	$X=(20)(200)/(80)= 50$
A	20% Permeate - 70C, 30 min - Then 0.5%Lactozyme3000 at 35C,pH6.5(w/HCl)-Then pH4.0(w/HCl), Evap to 60 & 80% Solids	
	Add 1700 gm DI water to glass reactor in water bath such that reaction mix temp is 75C	
	Add 425 gm dried Permeate slowly to reactor while mixing until all Permeate is wetted and evenly suspended	
	Mix at 70C for 30 min	
	Cool to 35C while mixing	
	Adjust pH to 6.5 with NaOH or HCl while mixing	
	Record pH and control pH at 6.5	
	Add 2.13 gm Lactozyme3000 to 50 ml water in beaker and mix well	
	Add well mixed Lactozyme3000 to 20% Permeate at 35C while mixing	
	At 0, 3, 6, 9 and 12 hrs after Lactozyme3000 addition sample for HPLC Sugar Assays (see Sugar Test Sample Prep Tab) - LAC-090209-A0,A3,A6,A9,A12	
	At 0, 3, 6, 9 and 12 hrs after Lactozyme addition - Take a samples for 80% and 60% Evap, drop pH to 4.0 with Conc HCl and Rotovap first to 80% solids - If no sediment, Stop and do not rotovap to 60% solids. If sediment rotovap second sample to 60% solids. Use designated amount above (200gm --> 50gm for 80% adn 150.38gm --> 50gm for 60%) - Label LAC-090209-A3-80/60, -A6-80/60, -A9-80/60 and -A12-80/60 for 80% and if necessary 60% solids, respectively.	
	DO NOT do Viscosity on 60 and 80% solids samples	
	Store 80% and if necessary 60% solids samples in cold and take pics at 1 day and periodically over next week	
	Pre-weigh 1 liter Rotovap flask	Wt Flask
	Record weight of Rotovap flask	Target Wt
	Transfer Calculated gm (see above) into 1 liter Rotovap flask and refrigerate remainder of reaction mixture for higher % solids tests	
	Do % Solids on sample from remaining "20% Solids" mixture	
B	20% Permeate - 70C, 30 min - Then 0.2%Lactozyme3000 at 35C,pH6.5(w/HCl)-Then pH4.0(w/HCl), Evap to 60 & 80% Solids	
	Add 1700 gm DI water to glass reactor in water bath such that reaction mix temp is 75C	
	Add 425 gm dried Permeate slowly to reactor while mixing until all Permeate is wetted and evenly suspended	
	Mix at 70C for 30 min	
		ml
		pH
		% Solids
		Time

Figure 10

Figure 10 (Cont'd)

Na2SO3 Calculator		
Na2SO3	126.04 g/mole	
% of Soy	3.00%	% of Soy
gm/Liter	12.75 g Na2SO3/liter	
Molar	0.1012 mole Na2SO3/liter	

Na2SO3	126.04 g/mole	
% of Soy	2.00%	% of Soy
gm/Liter	8.5 g Na2SO3/liter	
Molar	0.0674 mole Na2SO3/liter	

Na2SO3	126.04 g/mole	
% of Soy	1.00%	% of Soy
gm/Liter	4.25 g Na2SO3/liter	
Molar	0.0337 mole Na2SO3/liter	

Water (gm)	1,700.00
Permeate	425.00
Lactozyme3000	2.1250
	0.0000
	0.0000
	0.00
Solids (pph)	25.00
Solids (%)	20.00%

Water (gm)	1,700.00
Permeate	425.00
Lactozyme3000	0.8500
	0.0000
	0.0000
	0.00
Solids (pph)	25.00
Solids (%)	20.00%

Water (gm)	1,700.00
Permeate	425.00
Lactozyme3000	0.4250
	0.0000
	0.0000
	0.00
Solids (pph)	25.00
Solids (%)	20.00%

#### Assumptions for LAC:

Lactozyme3000L = 3000 LAU/ml (1 LAU = 1 umole glucose/min) (Sigma price = \$129.50/250ml)  
(pH6.5 / 37C / 4.5% w/w Lactose / 30 min / 0.035-0.1 LAU/gm)

1 ml Lactozyme3000L → 3x10<sup>3</sup> umoles lactose \* 1 mole lactose/10<sup>6</sup> umoles lactose \* 342 gm lactose/mole lactose = 1.026 gm lactose/min

Therefore, for 1% enzyme loading (1 gm Lactozyme3000L/100 gm lactose) it will take approx 100 min to hydrolyze 100 gm lactose)

1200.00 800.00  
400.00  
800.00 600.00

Figure 10 (Cont'd)

LAC-090209	(20%Perm-0.5 0.231% Lactocyna3000-35C pH-5.12ms-HPLC-pH4 Evac)
AP-Parameter	Value
Lactocyna300L	0.5% on Permaseal solids
pH	5.5-Controlled
Hydrolysis Temp	40C (Rx Mx Temp)
Lactose Source	Dried Permaseal
% Permaseal Solids	20%
Order	Permaseal-75C 1hr then 40C
pH After Enz Reaction	4.0 w/0.5% HCl then Rotap
Lactocyna300L	0.2% on Permaseal solids
pH	5.5-Controlled
Hydrolysis Temp	40C (Rx Mx Temp)
Lactose Source	Dried Permaseal
% Permaseal Solids	20%
Order	Permaseal-75C 1hr then 40C
pH After Enz Reaction	4.0 w/0.5% HCl then Rotap
Lactocyna300L	0.1% on Permaseal solids
pH	5.5-Controlled
Hydrolysis Temp	40C (Rx Mx Temp)
Lactose Source	Dried Permaseal
% Permaseal Solids	20%
Order	Permaseal-75C 1hr then 40C
pH After Enz Reaction	4.0 w/0.5% HCl then Rotap
50% Solids	Rotap to 50 % Solids - Setting Values
60% Solids	Rotap to 60 % Solids - Setting Values
70% Solids	Rotap to 70 % Solids - Setting Values
80% Solids	Rotap to 80 % Solids - Setting Values

Figure 11

Experiment Number:	LAC-098209	(20% Perm-0.5, 0.2, 0.1% Lactozyme3000-35C pH6.5, 12hrs-HPLC pH4 Evap)				
Sample #	Description	pH	Setting	HPLC Sugars	% Solids	Viscosity
LAC090208-A0	20% Perm-0.5% Lacto3000-0hr	X	Pics	X	X	
LAC090209-A3	20% Perm-0.5% lacto3000-2hr	X		X		
LAC090209-A6	20% Perm-0.5% lacto3000-4hr	X		X		
LAC090209-A9	20% Perm-0.5% Lacto3000-6hr	X		X		
LAC090209-A12	20% Perm-0.5% lacto3000-8hr	X		X		
LAC090209-A3-B0	20% Perm-0.5% lacto3000-3hr-80%	X	X		X	
LAC090209-A3-B0	20% Perm-0.5% lacto3000-3hr-80%	X	X		X	
LAC090209-A6-B0	20% Perm-0.5% lacto3000-6hr-80%	X	X		X	
LAC090209-A6-B0	20% Perm-0.5% lacto3000-6hr-80%	X	X		X	
LAC090209-A9-B0	20% Perm-0.5% Lacto3000-9hr-80%	X	X		X	
LAC090209-A9-B0	20% Perm-0.5% lacto3000-9hr-80%	X	X		X	
LAC090209-A12-B0	20% Perm-0.5% lacto3000-12hr-80%	X	X		X	
LAC090209-A12-B0	20% Perm-0.5% lacto3000-12hr-80%	X	X		X	
LAC090209-B0	20% Perm-0.2% lacto3000-0hr	X		X	X	
LAC090209-B3	20% Perm-0.2% lacto3000-2hr	X		X		
LAC090209-B6	20% Perm-0.2% lacto3000-4hr	X		X		
LAC090209-B9	20% Perm-0.2% lacto3000-6hr	X		X		
LAC090209-B12	20% Perm-0.2% lacto3000-8hr	X		X		
LAC090209-B3-B0	20% Perm-0.2% Lacto3000-3hr-80%	X	X		X	
LAC090209-B3-B0	20% Perm-0.2% lacto3000-3hr-80%	X	X		X	
LAC090209-B6-B0	20% Perm-0.2% lacto3000-6hr-80%	X	X		X	X
LAC090209-B6-B0	20% Perm-0.2% Lacto3000-6hr-80%	X	X		X	
LAC090209-B9-B0	20% Perm-0.2% lacto3000-9hr-80%	X	X		X	
LAC090209-B9-B0	20% Perm-0.2% lacto3000-9hr-80%	X	X		X	
LAC090209-B12-B0	20% Perm-0.2% lacto3000-12hr-80%	X	X		X	
LAC090209-B12-B0	20% Perm-0.2% lacto3000-12hr-80%	X	X		X	X
LAC090209-C0	20% Perm-0.1% lacto3000-0hr	X		X	X	
LAC090209-C3	20% Perm-0.1% lacto3000-2hr	X		X		
LAC090209-C6	20% Perm-0.1% lacto3000-4hr	X		X		
LAC090209-C9	20% Perm-0.1% Lacto3000-6hr	X		X		
LAC090209-G12	20% Perm-0.1% lacto3000-8hr	X		X		
LAC090209-C3-B0	20% Perm-0.1% lacto3000-3hr-80%	X	X		X	
LAC090209-C3-B0	20% Perm-0.1% Lacto3000-3hr-80%	X	X		X	
LAC090209-C6-B0	20% Perm-0.1% lacto3000-6hr-80%	X	X		X	X
LAC090209-C6-B0	20% Perm-0.1% lacto3000-6hr-80%	X	X		X	
LAC090209-C9-B0	20% Perm-0.1% lacto3000-9hr-80%	X	X		X	
LAC090209-C9-B0	20% Perm-0.1% lacto3000-9hr-80%	X	X		X	
LAC090209-C12-B0	20% Perm-0.1% lacto3000-12hr-80%	X	X		X	X
LAC090209-C12-B0	20% Perm-0.1% lacto3000-12hr-80%	X	X		X	

Figure 12



Experiment Number:	LAC-090209
	{20% Perm-0.5, 0.2, 0.1% Lactozyme3000-35C, pH6.5, 12hrs-HPLC, pH4, Evap}
Glucose Test Sample Prep	
1	Place 5 ml sample aliquot in 15 ml centrifuge tube
2	Add 0.1 ml 10% HCl to sample and mix. (if nozyme kit step - should drop pH to <3. May have to adjust amount of acid)
3	Note: until no solids are visible, no turbidness = clear solution
4	Adjust pH to <4 with HCl if necessary
5	DO NOT FILTER, store in refrigerator for HPLC analysis

Figure 12 (cont.)

LAC-080209	(20% Perm-0.5, 0.2 G 1% Lactzyme 3000-35C, pH 5.12hrs-HPLC, pH4 Evap)	% Lactase	% solids1	% solids2	% solids3	points(AVG)
LAC080209-A0		0.50				#DIV/0!
LAC080209-A1-60		0.50				#DIV/0!
LAC080209-A3-80		0.50				#DIV/0!
LAC080209-A5-80		0.50				#DIV/0!
LAC080209-A6-80		0.50				#DIV/0!
LAC080209-A8-60		0.50				#DIV/0!
LAC080209-A9-80		0.50				#DIV/0!
LAC080209-A12-60		0.50				#DIV/0!
LAC080209-A12-80		0.50				#DIV/0!
						#DIV/0!
LAC080209-B0		0.20				#DIV/0!
LAC080209-B3-60		0.20				#DIV/0!
LAC080209-B3-80		0.20				#DIV/0!
LAC080209-B6-60		0.20				#DIV/0!
LAC080209-B6-80		0.20				#DIV/0!
LAC080209-B8-60		0.20				#DIV/0!
LAC080209-B8-80		0.20				#DIV/0!
LAC080209-B12-60		0.20				#DIV/0!
LAC080209-B12-80		0.20				#DIV/0!
						#DIV/0!
LAC080209-C0		0.10				#DIV/0!
LAC080209-C3-60		0.10				#DIV/0!
LAC080209-C3-80		0.10				#DIV/0!
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LAC080209-C8-30		0.10				#DIV/0!
LAC080209-C9-60		0.10				#DIV/0!
LAC080209-C9-30		0.10				#DIV/0!
LAC080209-C12-60		0.10				#DIV/0!
LAC080209-C12-80		0.10				#DIV/0!
						#DIV/0!

Figure 13

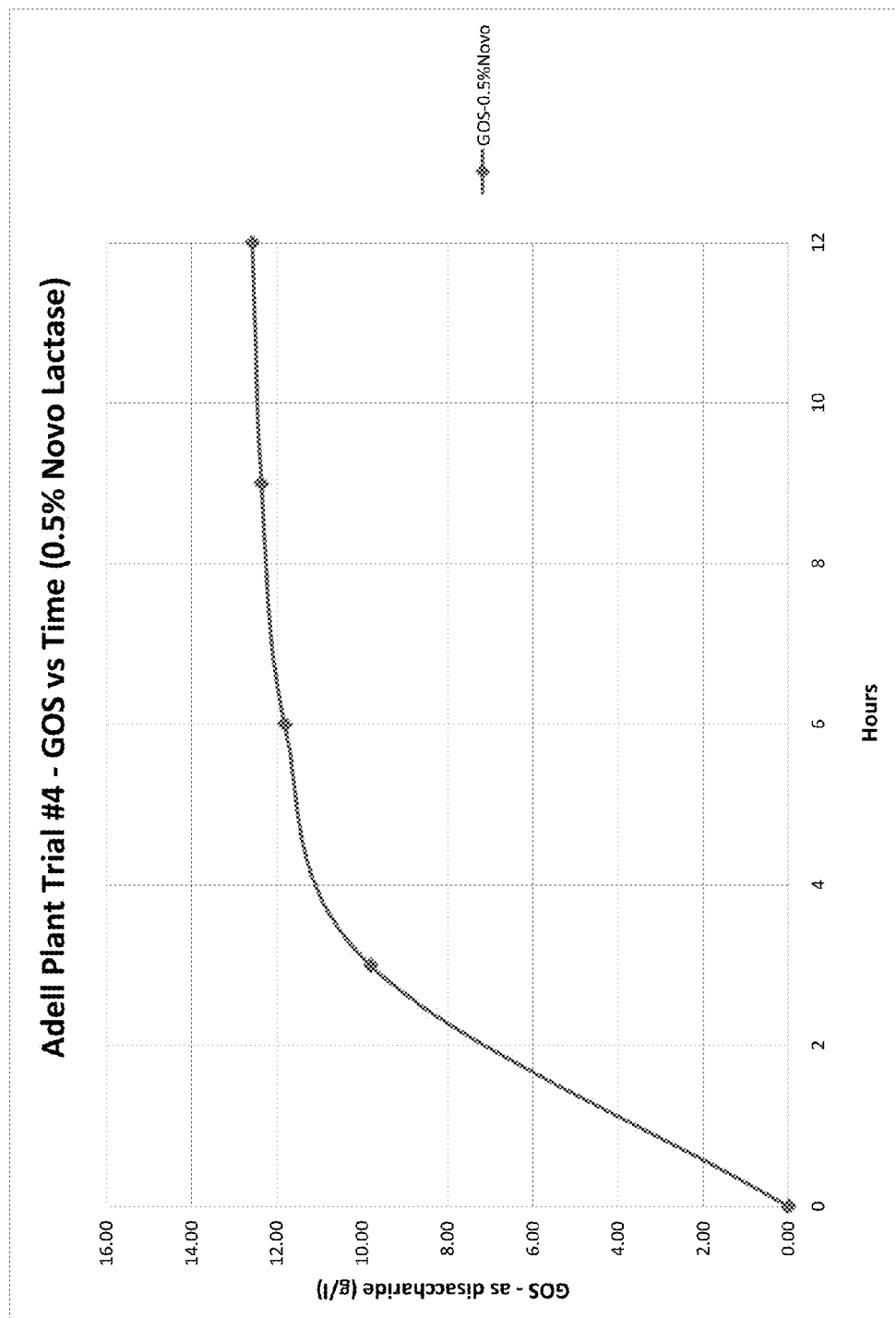


Figure 14

Adell Plant Trial #4 - Lactose vs Time (0.5% Novo Lactase)

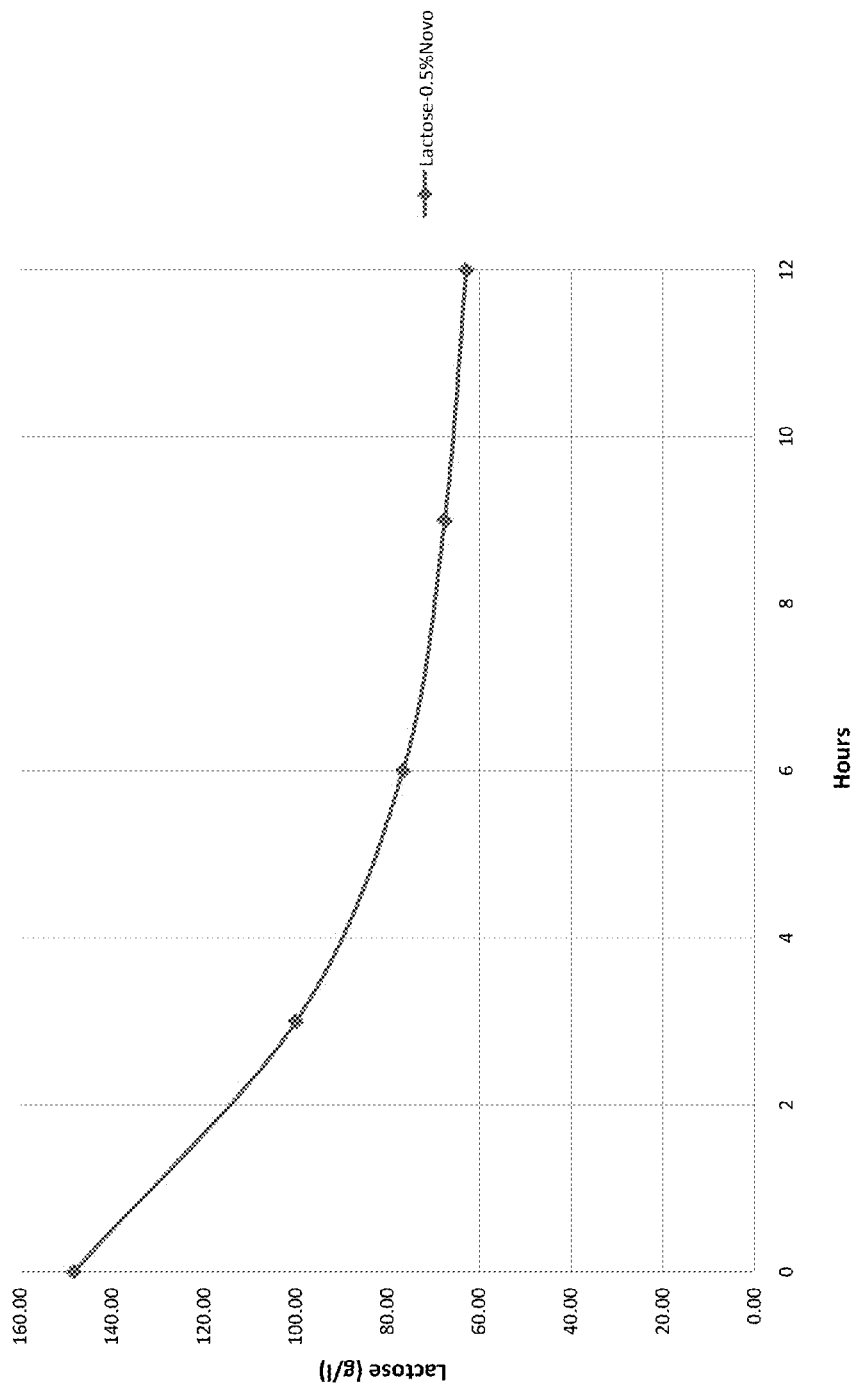


Figure 15

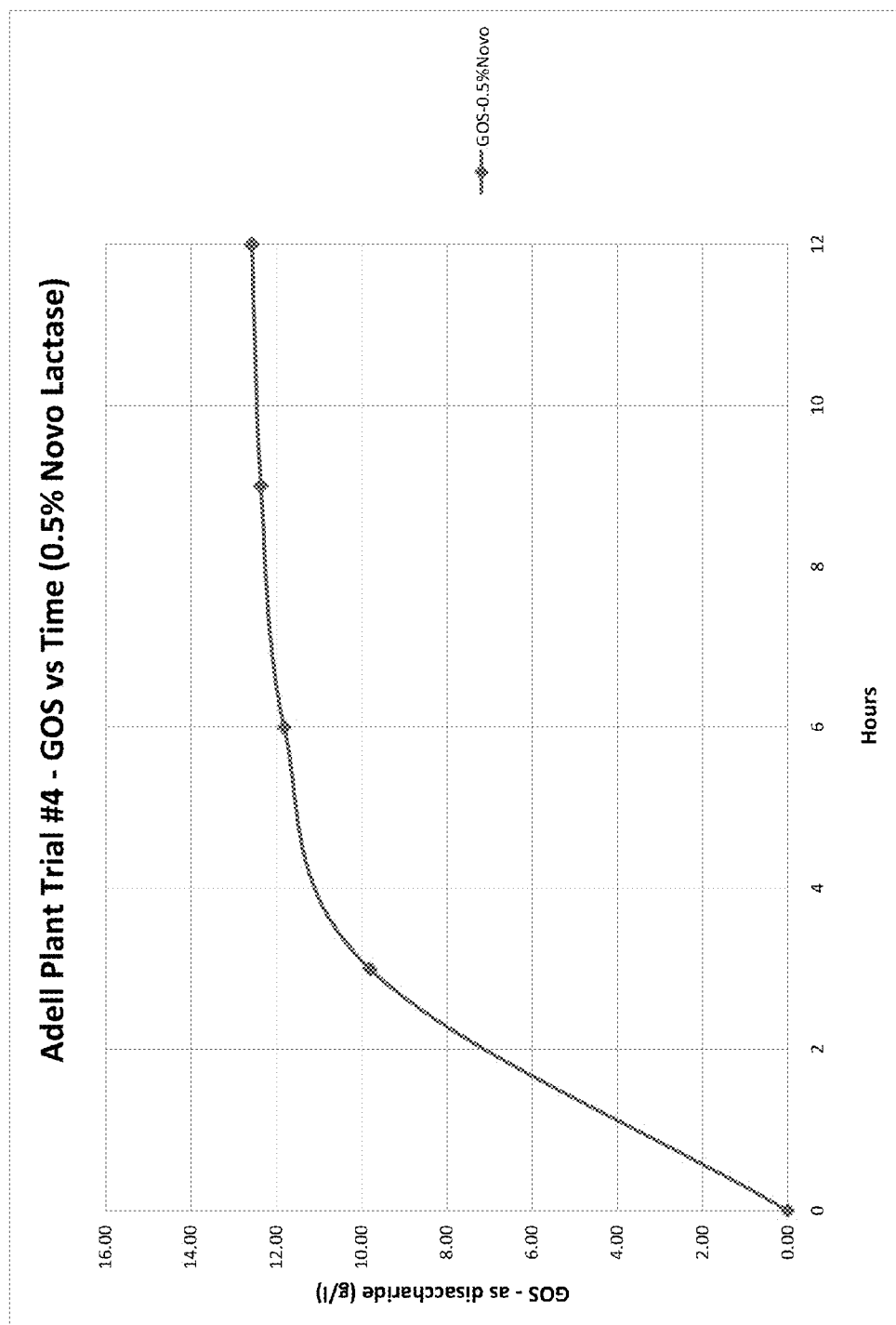


Figure 16

Novel Lactocypine 200R (NL)										Lactose		Glucose		Galactose	
Sample										Lactose		Glucose		Galactose	
Lactocypine Level										Lactose		Glucose		Galactose	
20% Permeate										20% Permeate		20% Permeate		20% Permeate	
0.30%										0.30%		0.30%		0.30%	
1st rep										1st rep		1st rep		1st rep	
2nd rep										2nd rep		2nd rep		2nd rep	
AVG										AVG		AVG		AVG	
SD										SD		SD		SD	
RSD										RSD		RSD		RSD	
Lactose (moles)										Lactose (moles)		Lactose (moles)		Lactose (moles)	
AVG										AVG		AVG		AVG	
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AVG										AVG		AVG		AVG	
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[illegible]

Figure 18

[illegible]

Figure 19



# LAC-090209A-0.5% Novo, pH6.5

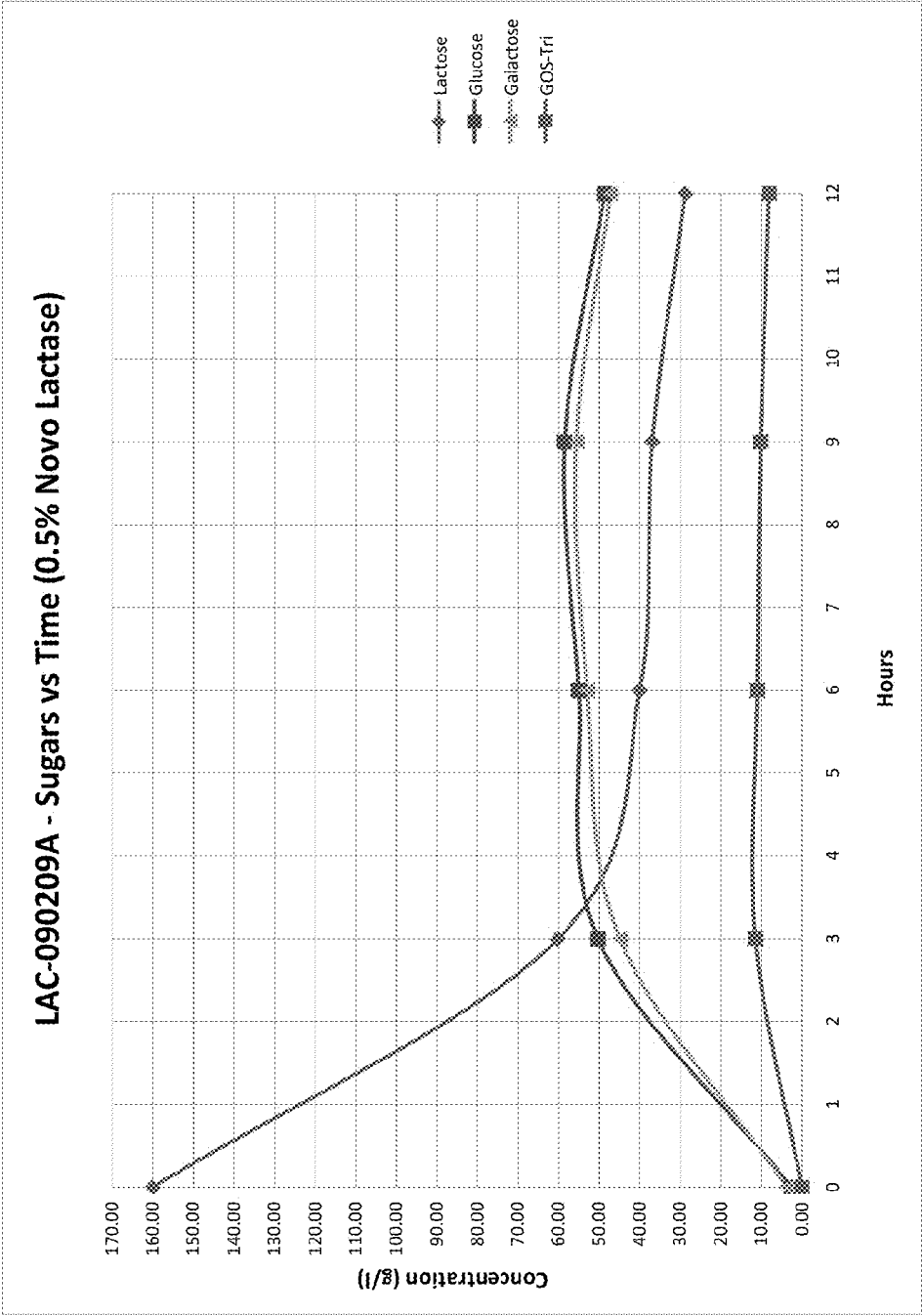


Figure 20

LAC-090209B-0.2% Novo, pH6.5

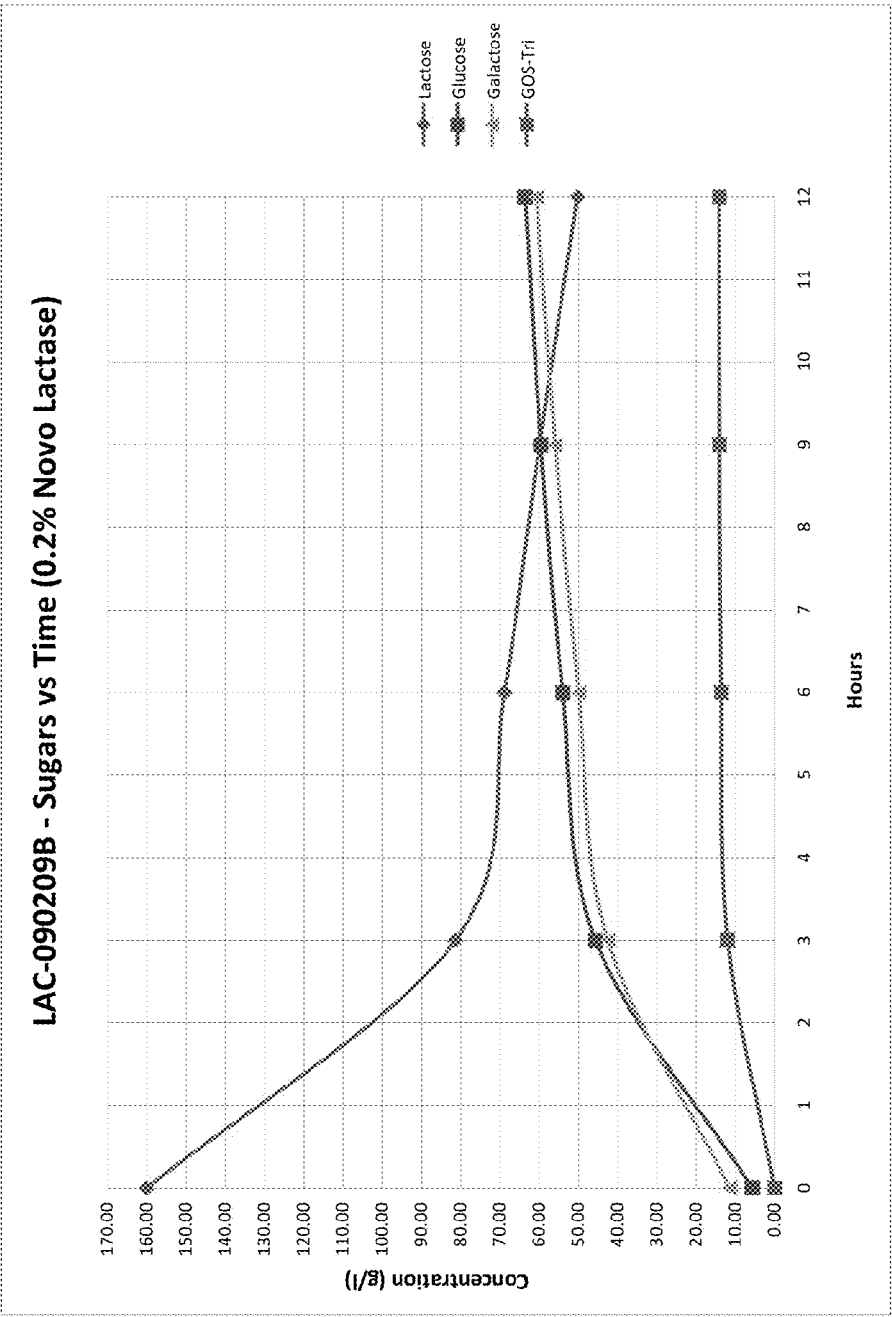


Figure 21

# LAC-090209C-0.1% Novo, pH6.5

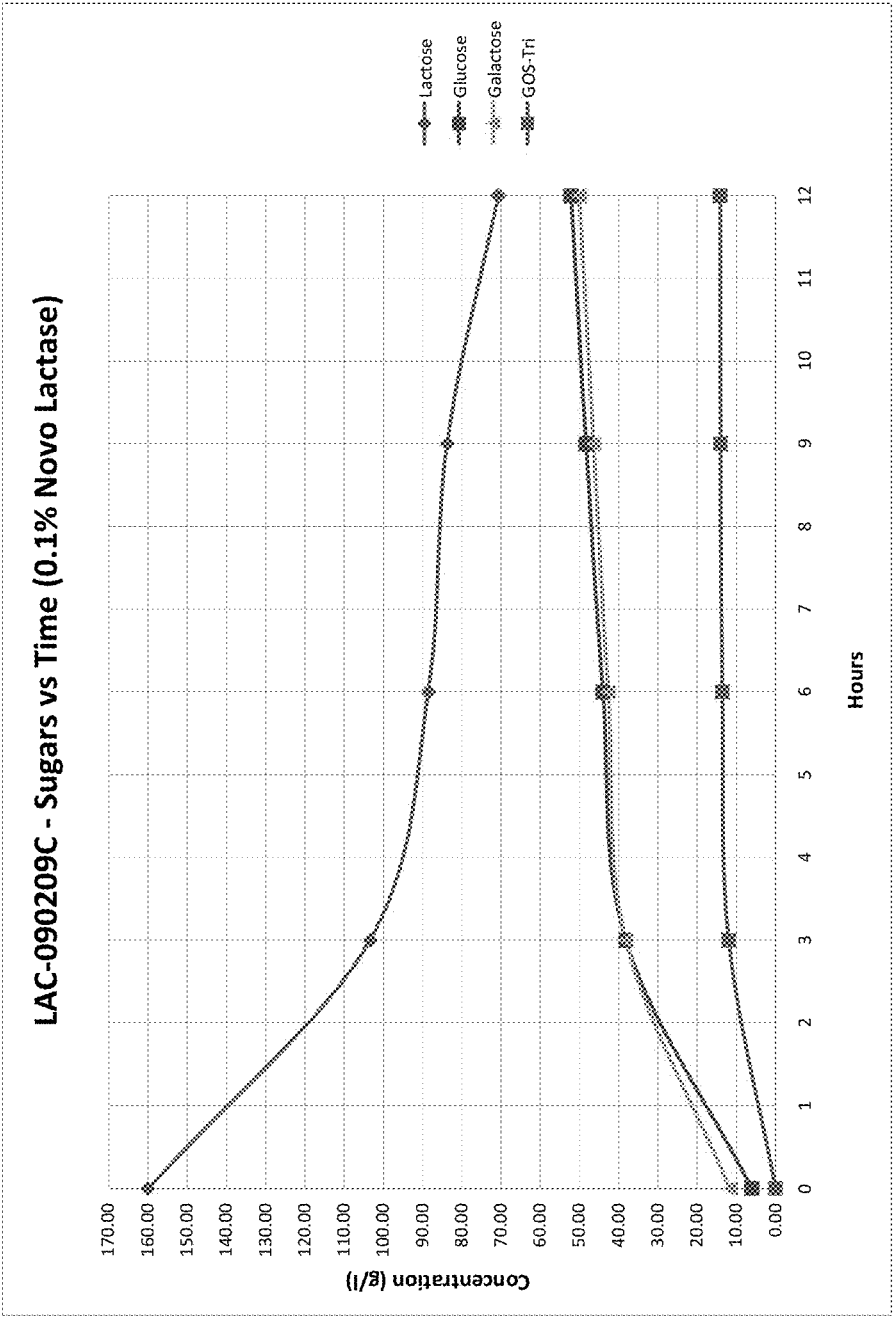


Figure 22

# LAC-090209-0.5,0.2,0.1% Novo, pH6.5

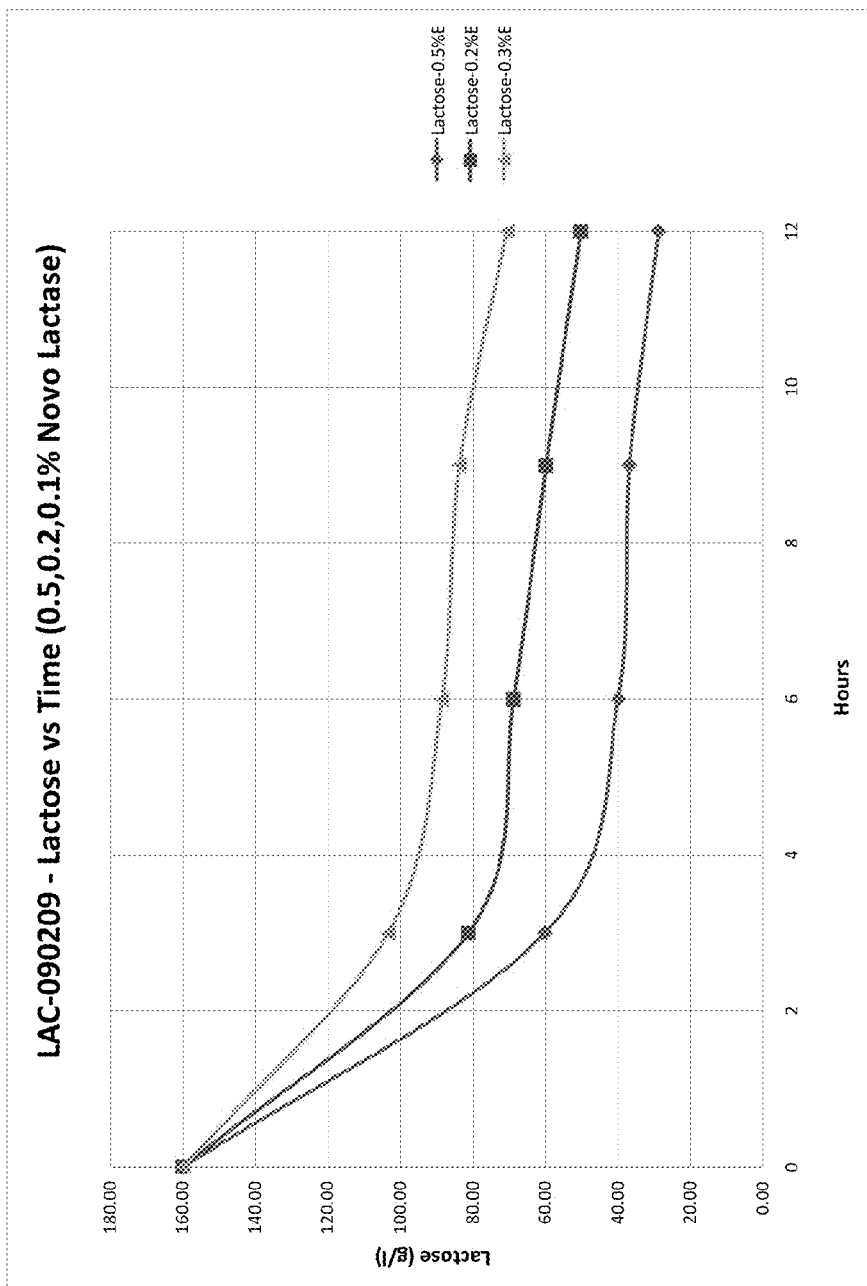


Figure 23

# LAC-090209-0.5,0.2,0.1% Novo, pH6.5

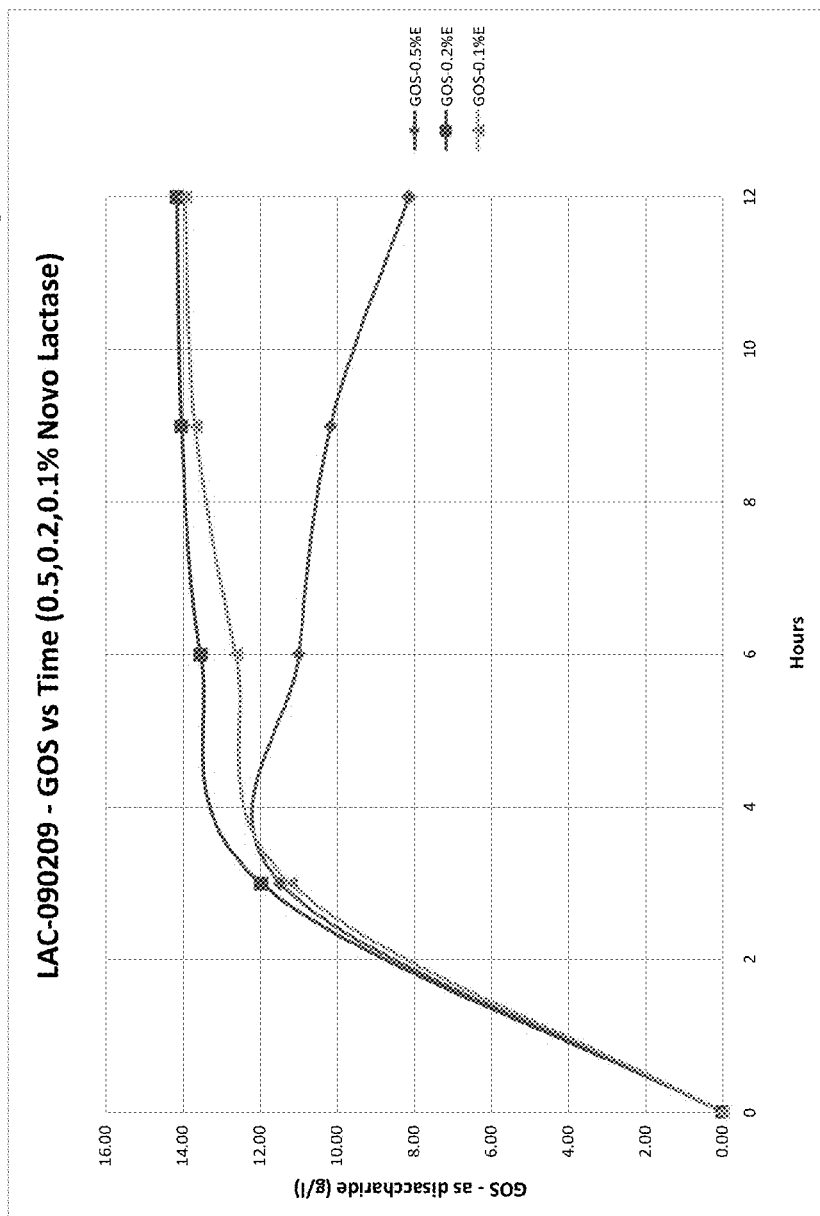


Figure 24

Experiment Number: Notebook Reference:	LAC-090209	(20%Perm-0.5:0.2:0.1% Lactozyme3000-35C, pH6.5, 12hrs-HPLC, pH4, Evap)
Objective:	To determine the effect of hydrolysis of 20% Perm with Novo Lactozyme3000 at 0.5, 0.2 and 0.1% on Permeate Solids, at 35C, pH6.5 for 12hrs, followed by adjusting pH to 4.0 with conc HCl, followed by evaporation to 60 & 80% solids.	
Materials:		
A	1700.0 gm Water	
	425.0 gm Dried Permeate	
	2.13 gm Novo Lactozyme 3000L	
B	1700.0 gm Water	
	425.0 gm Dried Permeate	
	0.85 gm DFL5000	
C	1700.0 gm Water	
	425.0 gm Dried Permeate	
	0.43 gm DFL5000	
50	Evap to 50% Solids	
	Evap 125 gm to 140 gm	$(20\%)*(125)=(50\%)*X$ $X=(20)*(125)/(50)=$ 50
60	Evap to 60% Solids	$(20\%)*(150.38)=(60\%)*X$ $X=(20)*(150.38)/(60)=$ 50
70	Evap 150.38 gm to 133 gm	
	Evap to 70% Solids	$(20\%)*(174.63)=(70\%)*X$ $X=(20)*(174.63)/(70)=$ 50
80	Evap 174.63 gm to 136 gm	
	Evap to 80% Solids	$(20\%)*(200)=(80\%)*X$ $X=(20)*(200)/(80)=$ 50
200 to 50gm	Evap 200 gm to 50 gm	
A	20% Permeate - 70C, 30 min - Then 0.5% Lactozyme3000 at 35C, pH6.5(w/HCl)-Then pH4.0(w/HCL), Evap to 60 & 80% Solids	
	Add 1700 gm DI water to glass reactor in water bath such that reaction mix temp is 75C	
	Add 425 gm dried Permeate slowly to reactor while mixing until all Permeate is wetted and evenly suspended	
	Mix at 70C for 30 min	
	Cool to 35C while mixing	
	Adjust pH to 6.5 with NaOH or HCl while mixing	
	Record pH and control pH at 6.5	
	Add 2.13 gm Lactozyme3000 to 50 ml water in beaker and mix well	
	Add well mixed Lactozyme3000 to 20% Permeate at 35C while mixing	
	At 0, 3, 6, 9 and 12 hrs after Lactozyme3000 addition sample for HPLC Sugar Assays (see Sugar Test Sample Prep Tab) - LAC-090209-A0, A3, A6, A9, A12	
	At 0, 3, 6, 9 and 12 hrs after Lactozyme addition - Take a samples for 80% and 60% Evap, drop pH to 4.0 with Conc HCl and Rotovap first to 80% solids - If no sediment, Stop and do not rotovap to 60% solids. If sediment rotovap second sample to 60% solids. Use designated amount above (200gm --> 50gm for 80% adn 150.38gm --> 50gm for 60%) - Label LAC-090209-A3-80/60, -A6-80/60, -A9-80/60 and -A12-80/60 for 80% and if necessary 60% solids, respectively.	
	DO NOT do Viscosity on 60 and 80% solids samples	
	Store 80% and if necessary 60% solids samples in cold and take pics at 1 day and periodically over next week	
	Pre-weigh 1 liter Rotovap flask	Wt Flask
	Record weight of Rotovap flask	Target Wt
	Transfer Calculated gm (see above) into 1 liter Rotovap flask and refrigerate remainder of reaction mixture for higher % solids tests	
	Do % Solids on sample from retaining "20% Solids" mixture	
B	20% Permeate - 70C, 30 min - Then 0.2% Lactozyme3000 at 35C, pH6.5(w/HCl)-Then pH4.0(w/HCL), Evap to 60 & 80% Solids	
	Add 1700 gm DI water to glass reactor in water bath such that reaction mix temp is 75C	
	Add 425 gm dried Permeate slowly to reactor while mixing until all Permeate is wetted and evenly suspended	
	Mix at 70C for 30 min	
		ml
		pH
		Time

Figure 25

	Cool to 35C while mixing				
	Adjust pH to 6.5 with NaOH or HCl while mixing				
	Record pH and control pH at 6.5				
	Add 0.85 gm Lactozyme3000 to 50 ml water in beaker and mix well				
	Add well mixed Lactozyme3000 to 20% Permeate at 35C while mixing				
	At 0, 3, 6, 9 and 12 hrs after Lactozyme3000 addition sample for HPLC Sugar Assays (see Sugar Test Sample Prep Tab) -				
	LAC-090209-B0,B3,B6,B9,B12				
	At 0, 3, 6, 9 and 12 hrs after Lactozyme addition - Take a samples for 80% and 60% Evap, drop pH to 4.0 with Conc HCl and Rotovap first to 80% solids - If no sediment, Stop and do not rotovap to 60% solids. If sediment rotovap second sample to 60% solids. Use designated amount above (200gm --> 50gm for 80% adn 150.38gm --> 50gm for 60%) - Label LAC-090209-B3-80/60, -B6-80/60, -B9-80/60 and -B12-80/60 for 80% and if necessary 60% solids, respectively.				
	DO NOT do Viscosity on 60 and 80% solids samples				
	Store 80% and if necessary 60% solids samples in cold and take pics at 1 day and periodically over next week				
	Pre-weigh 1 liter Rotovap flask	Wt Flask	Target Wt	% Solids	
	Record weight of Rotovap flask				
	Transfer Calculated gm (see above) into 1 liter Rotovap flask and refrigerate remainder of reaction mixture for higher % solids tests				
	Do % Solids on sample from remaining "20% Solids" mixture				
C	20% Permeate - 70C, 30 min - Then 0.1%Lactozyme3000 at 35C,pH6.5(w/HCl)-Then pH4.0(w/HCL), Evap to 60 & 80% Solids	ml	pH	Time	
	Add 1700 gm DI water to glass reactor in water bath such that reaction mix temp is 75C				
	Add 425 gm dried Permeate slowly to reactor while mixing until all Permeate is wetted and evenly suspended				
	Mix at 70C for 30 min				
	Cool to 35C while mixing				
	Adjust pH to 6.5 with NaOH or HCl while mixing				
	Record pH and control pH at 6.5				
	Add 0.43 gm Lactozyme3000 to 50 ml water in beaker and mix well				
	Add well mixed Lactozyme3000 to 20% Permeate at 35C while mixing				
	At 0, 3, 6, 9 and 12 hrs after Lactozyme3000 addition sample for HPLC Sugar Assays (see Sugar Test Sample Prep Tab) -				
	LAC-090209-C0,C3,C6,C9,C12				
	At 0, 3, 6, 9 and 12 hrs after Lactozyme addition - Take a samples for 80% and 60% Evap, drop pH to 4.0 with Conc HCl and Rotovap first to 80% solids - If no sediment, Stop and do not rotovap to 60% solids. If sediment rotovap second sample to 60% solids. Use designated amount above (200gm --> 50gm for 80% adn 150.38gm --> 50gm for 60%) - Label LAC-090209-C3-80/60, -C6-80/60, -C9-80/60 and -C12-80/60 for 80% and if necessary 60% solids, respectively.				
	DO NOT do Viscosity on 60 and 80% solids samples				
	Store 80% and if necessary 60% solids samples in cold and take pics at 1 day and periodically over next week				
	Pre-weigh 1 liter Rotovap flask	Wt Flask	Target Wt	% Solids	
	Record weight of Rotovap flask				
	Transfer Calculated gm (see above) into 1 liter Rotovap flask and refrigerate remainder of reaction mixture for higher % solids tests				
	Do % Solids on sample from remaining "20% Solids" mixture				

Figure 25 (Cont'd)

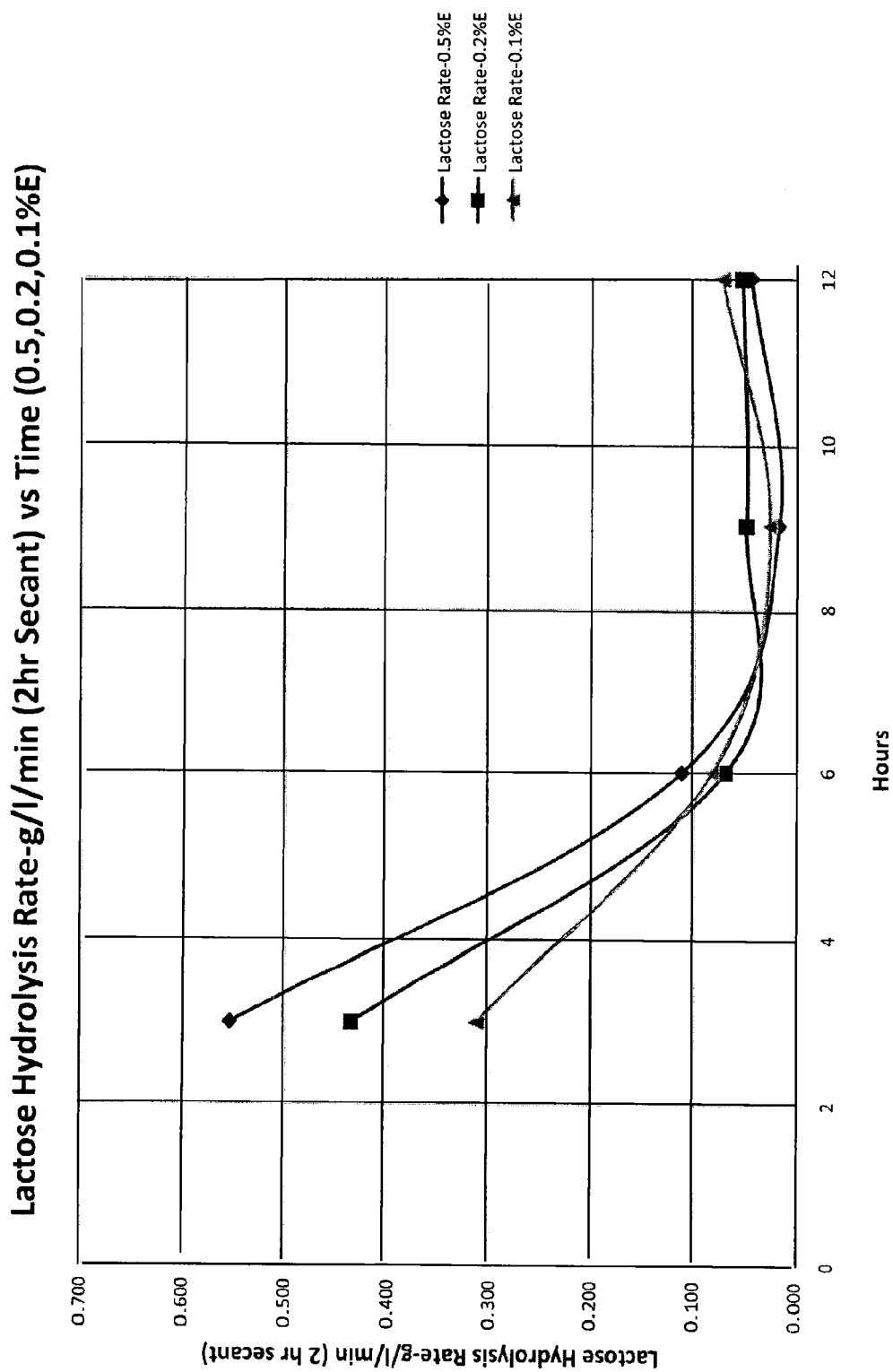


Figure 26



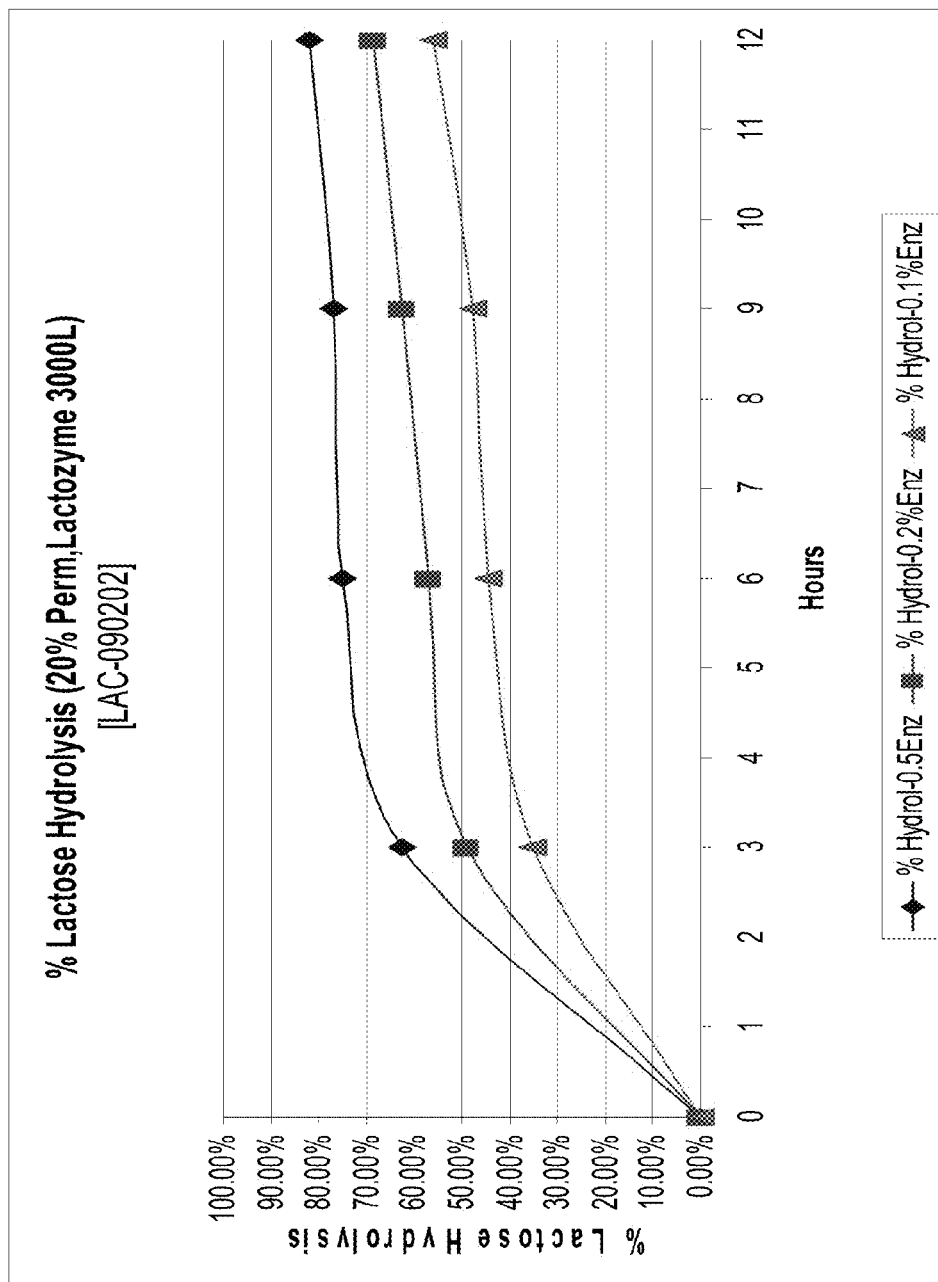


Figure 27

Category	1997-1998	1998-1999	1999-2000	2000-2001	2001-2002	2002-2003	2003-2004	2004-2005	2005-2006	2006-2007	2007-2008	2008-2009	2009-2010	2010-2011	2011-2012	2012-2013	2013-2014	2014-2015	2015-2016	2016-2017	2017-2018	2018-2019	2019-2020	2020-2021	2021-2022	2022-2023	2023-2024	2024-2025	2025-2026	2026-2027	2027-2028	2028-2029	2029-2030	2030-2031	2031-2032	2032-2033	2033-2034	2034-2035	2035-2036	2036-2037	2037-2038	2038-2039	2039-2040	2040-2041	2041-2042	2042-2043	2043-2044	2044-2045	2045-2046	2046-2047	2047-2048	2048-2049	2049-2050	2050-2051	2051-2052	2052-2053	2053-2054	2054-2055	2055-2056	2056-2057	2057-2058	2058-2059	2059-2060	2060-2061	2061-2062	2062-2063	2063-2064	2064-2065	2065-2066	2066-2067	2067-2068	2068-2069	2069-2070	2070-2071	2071-2072	2072-2073	2073-2074	2074-2075	2075-2076	2076-2077	2077-2078	2078-2079	2079-2080	2080-2081	2081-2082	2082-2083	2083-2084	2084-2085	2085-2086	2086-2087	2087-2088	2088-2089	2089-2090	2090-2091	2091-2092	2092-2093	2093-2094	2094-2095	2095-2096	2096-2097	2097-2098	2098-2099	2099-2100	2100-2101	2101-2102	2102-2103	2103-2104	2104-2105	2105-2106	2106-2107	2107-2108	2108-2109	2109-2110	2110-2111	2111-2112	2112-2113	2113-2114	2114-2115	2115-2116	2116-2117	2117-2118	2118-2119	2119-2120	2120-2121	2121-2122	2122-2123	2123-2124	2124-2125	2125-2126	2126-2127	2127-2128	2128-2129	2129-2130	2130-2131	2131-2132	2132-2133	2133-2134	2134-2135	2135-2136	2136-2137	2137-2138	2138-2139	2139-2140	2140-2141	2141-2142	2142-2143	2143-2144	2144-2145	2145-2146	2146-2147	2147-2148	2148-2149	2149-2150	2150-2151	2151-2152	2152-2153	2153-2154	2154-2155	2155-2156	2156-2157	2157-2158	2158-2159	2159-2160	2160-2161	2161-2162	2162-2163	2163-2164	2164-2165	2165-2166	2166-2167	2167-2168	2168-2169	2169-2170	2170-2171	2171-2172	2172-2173	2173-2174	2174-2175	2175-2176	2176-2177	2177-2178	2178-2179	2179-2180	2180-2181	2181-2182	2182-2183	2183-2184	2184-2185	2185-2186	2186-2187	2187-2188	2188-2189	2189-2190	2190-2191	2191-2192	2192-2193	2193-2194	2194-2195	2195-2196	2196-2197	2197-2198	2198-2199	2199-2200	2200-2201	2201-2202	2202-2203	2203-2204	2204-2205	2205-2206	2206-2207	2207-2208	2208-2209	2209-2210	2210-2211	2211-2212	2212-2213	2213-2214	2214-2215	2215-2216	2216-2217	2217-2218	2218-2219	2219-2220	2220-2221	2221-2222	2222-2223	2223-2224	2224-2225	2225-2226	2226-2227	2227-2228	2228-2229	2229-2230	2230-2231	2231-2232	2232-2233	2233-2234	2234-2235	2235-2236	2236-2237	2237-2238	2238-2239	2239-2240	2240-2241	2241-2242	2242-2243	2243-2244	2244-2245	2245-2246	2246-2247	2247-2248	2248-2249	2249-2250	2250-2251	2251-2252	2252-2253	2253-2254	2254-2255	2255-2256	2256-2257	2257-2258	2258-2259	2259-2260	2260-2261	2261-2262	2262-2263	2263-2264	2264-2265	2265-2266	2266-2267	2267-2268	2268-2269</
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Figure 28

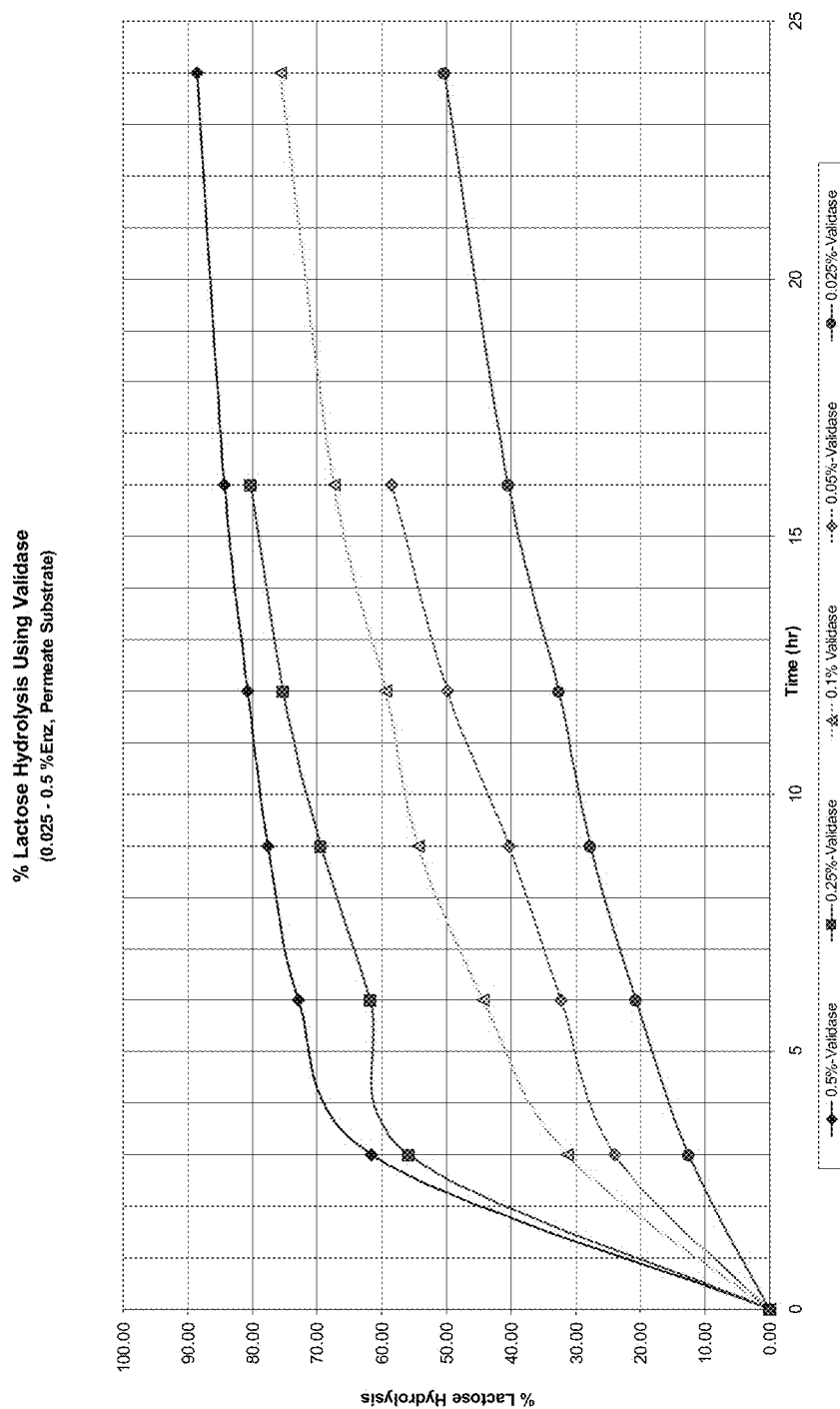


Figure 29

Enzymatic Hydrolysis Using Validase  
(0.50 gE / 100g Lac Loading, Permeate Substrate)

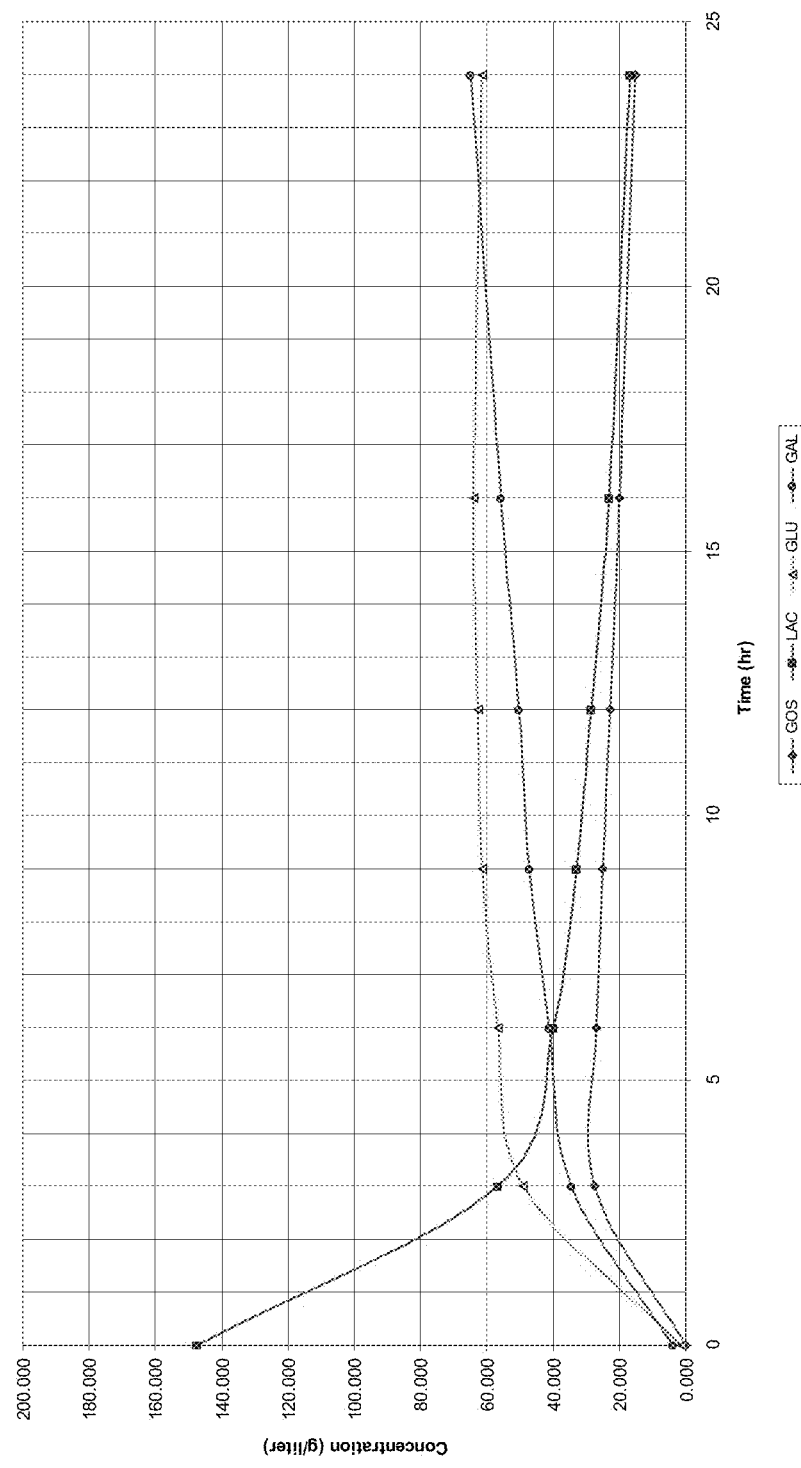


Figure 30

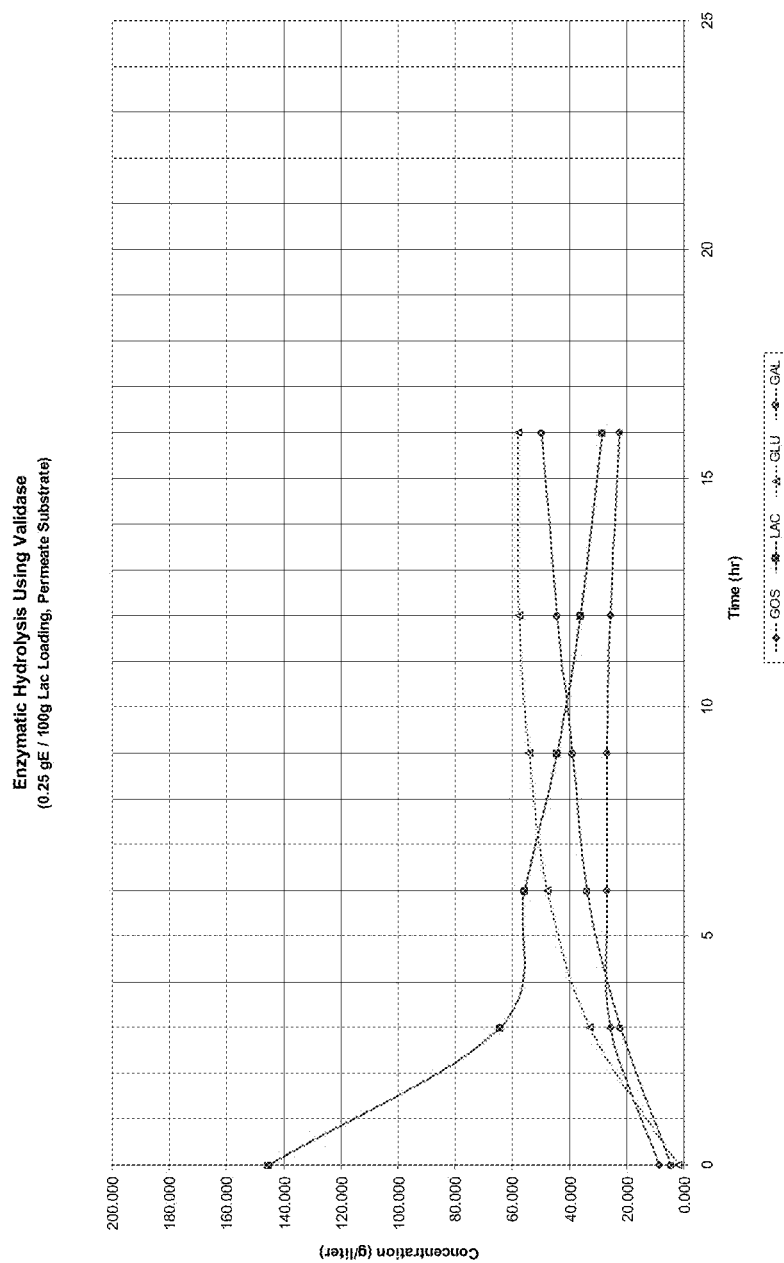


Figure 31

Enzymatic Hydrolysis Using Validase  
(0.10 gE / 100g Lac Loading, Permeate Substrate)

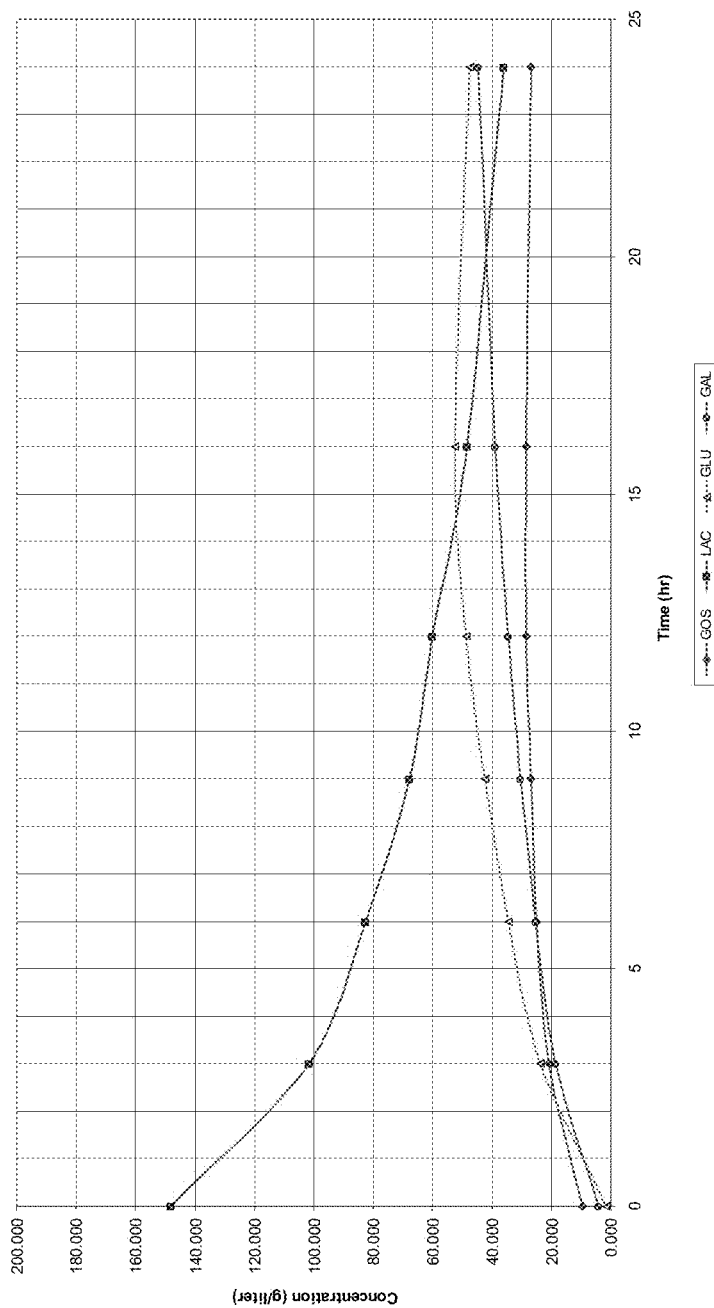


Figure 32

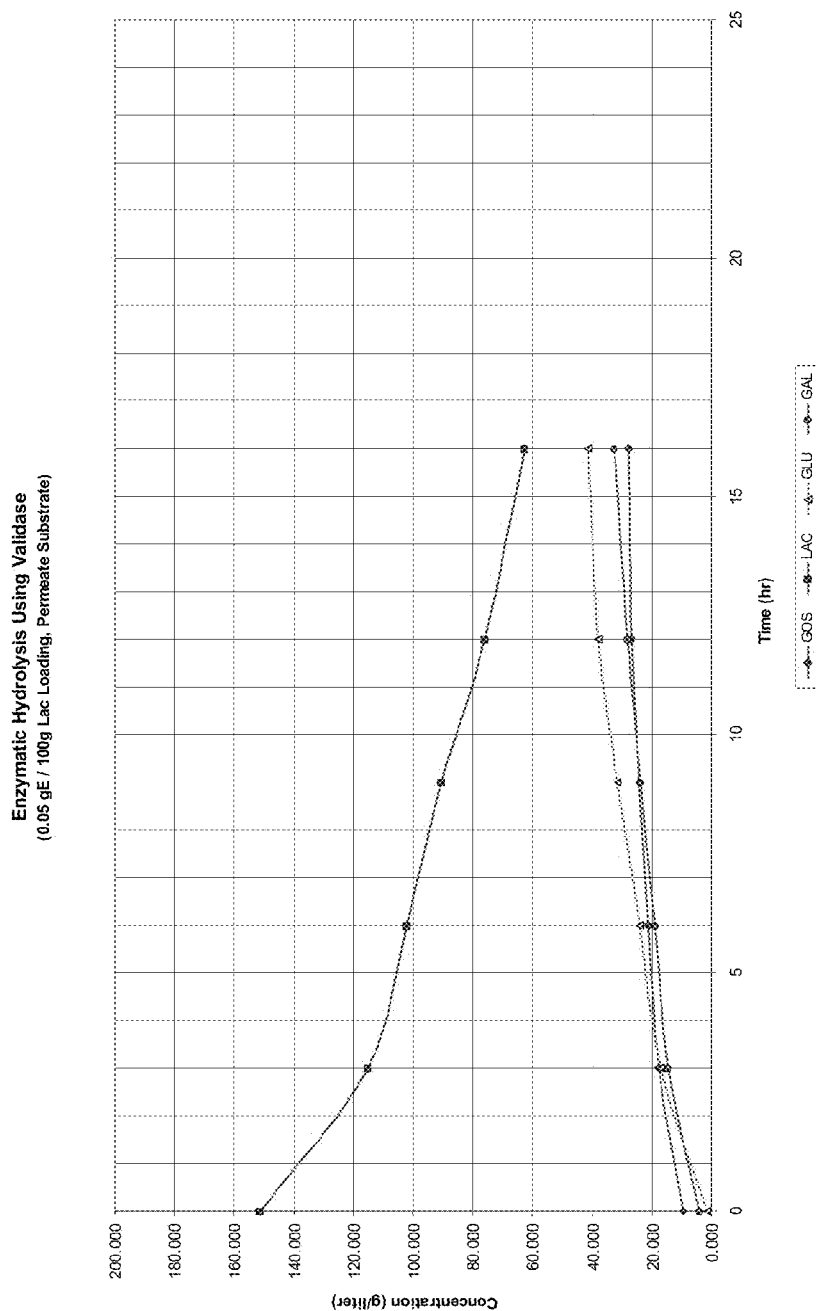


Figure 33

Enzymatic Hydrolysis Using Validase  
(0.025 gE / 100g Lac Loading, Permeate Substrate)

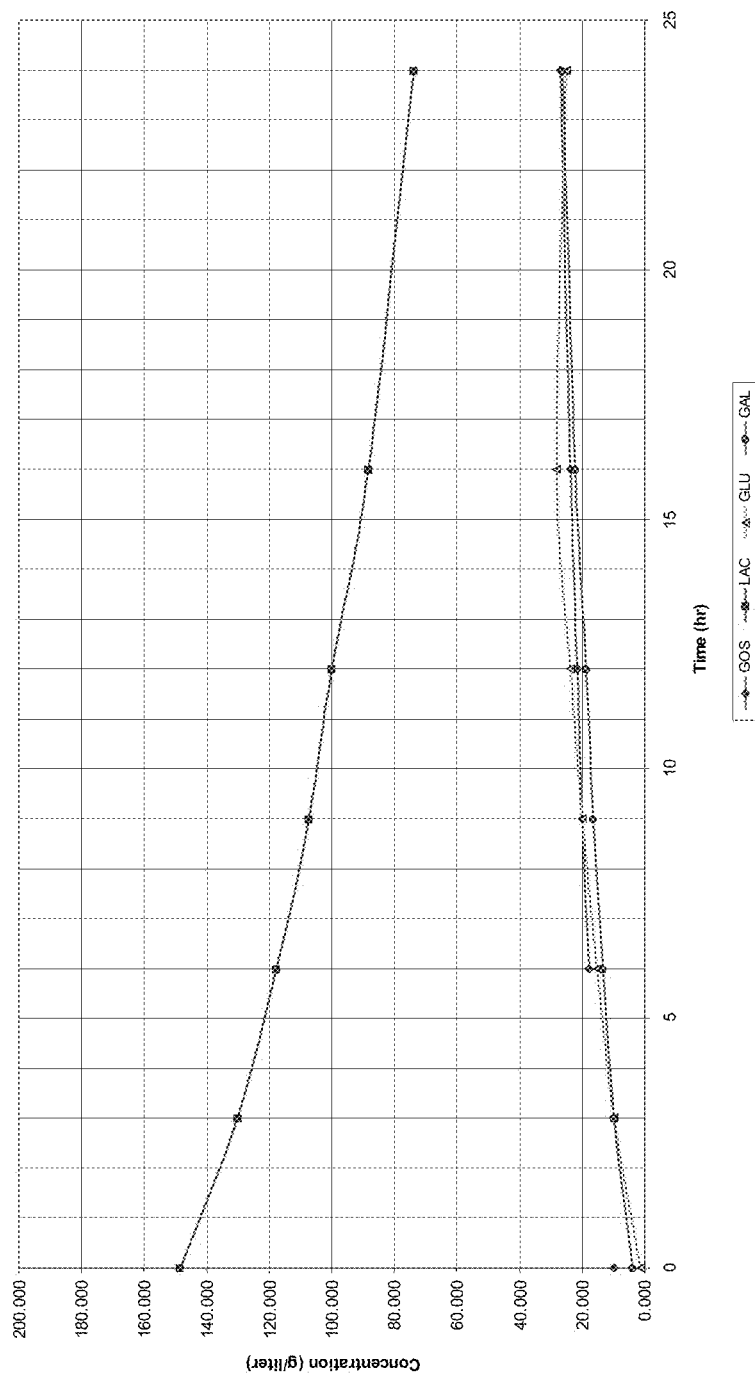


Figure 34



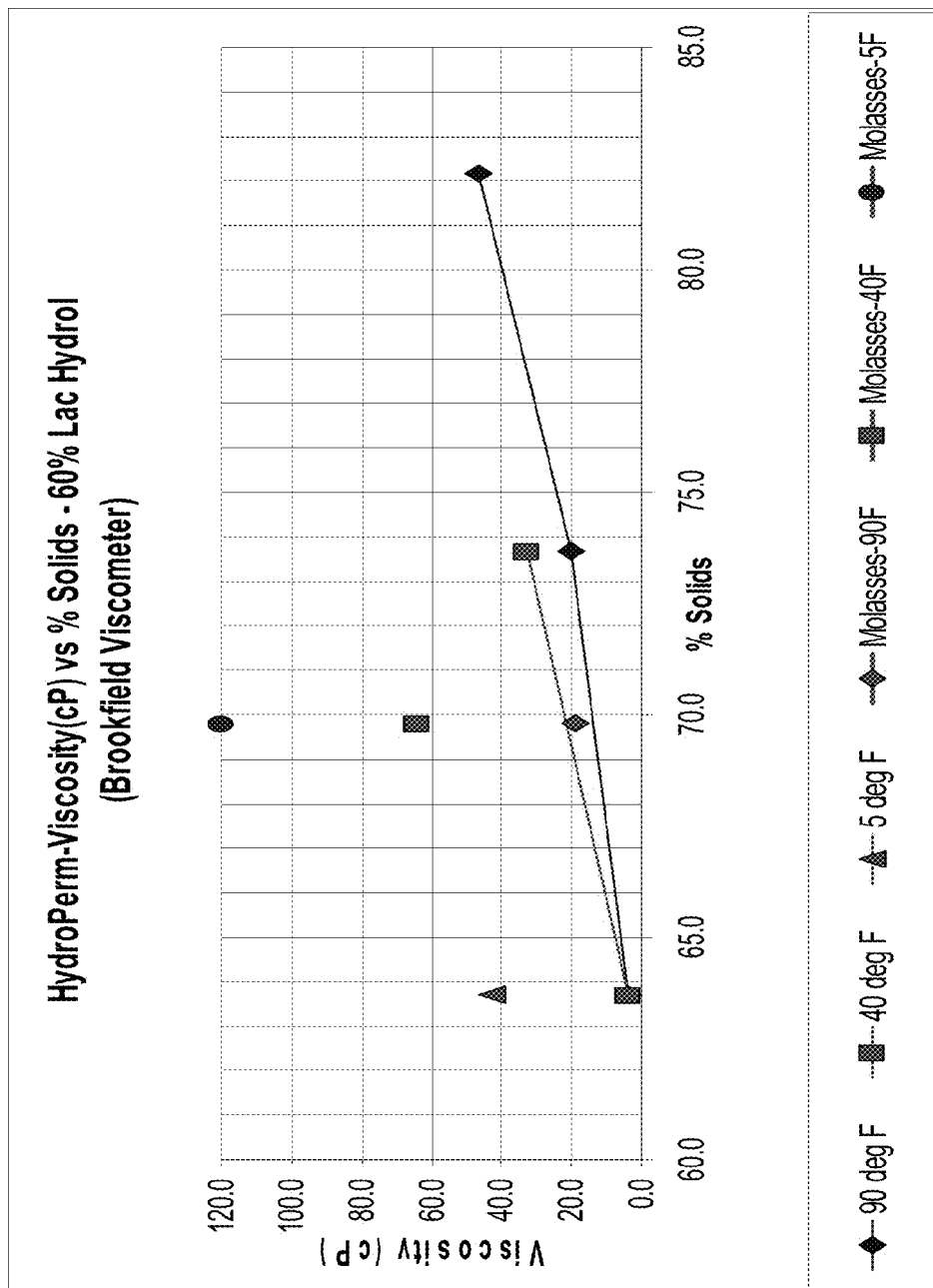


Figure 35

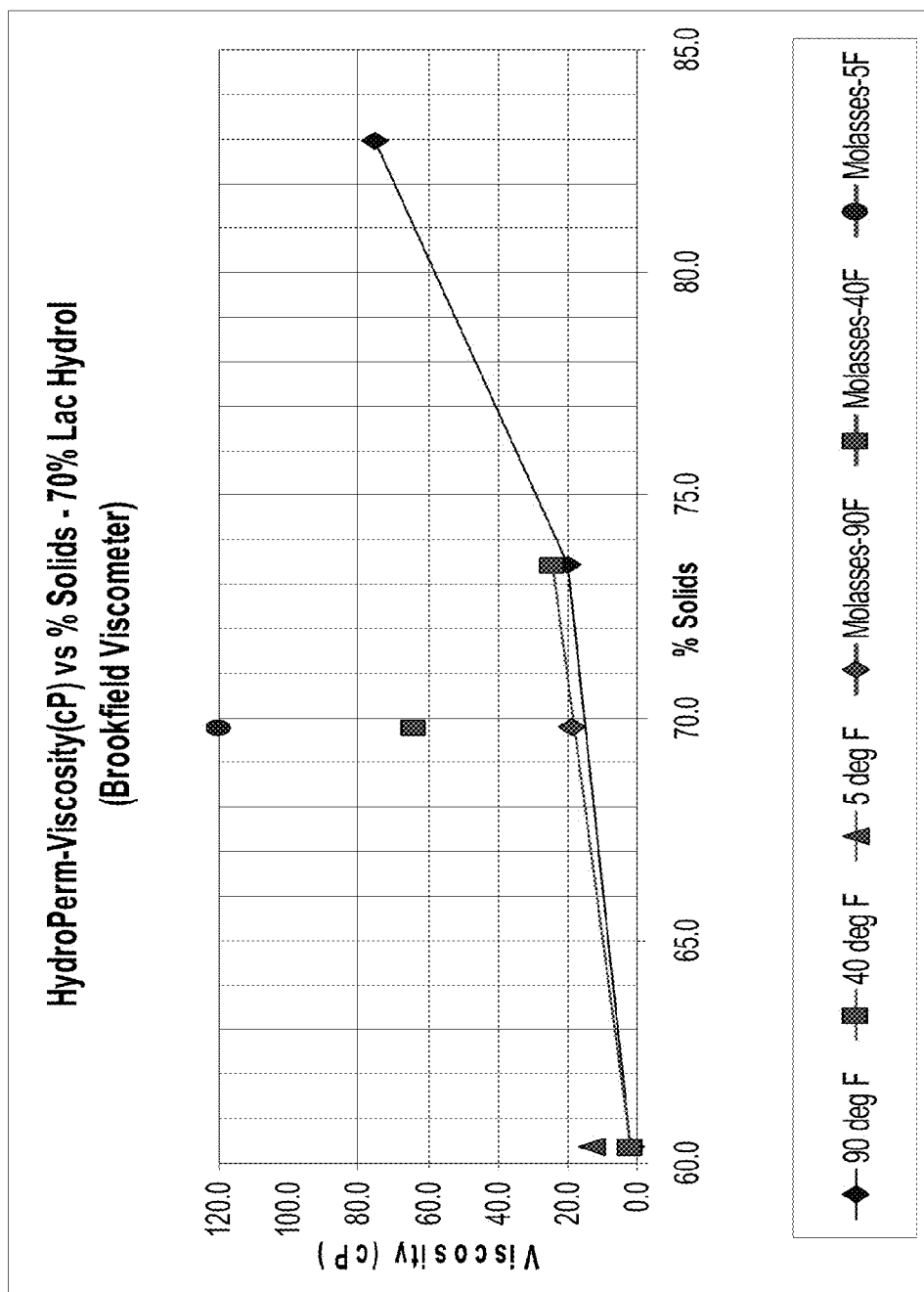


Figure 36

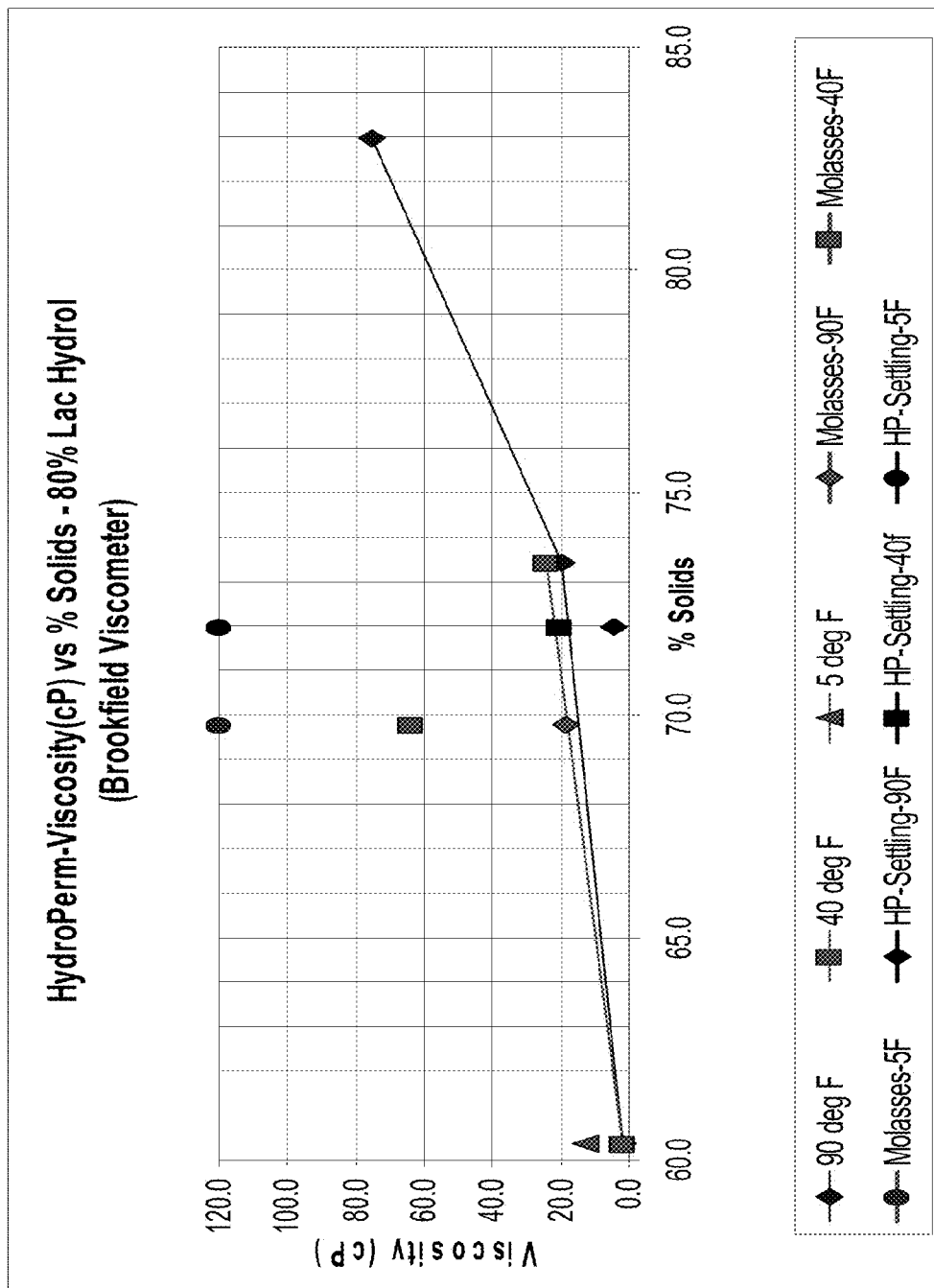


Figure 37

Sample #	Hydrol	% Solids	90F	40F	5F
Temp	Estim %	%	90	40	5
LAC-100208-A3hr-60	60	63.7	3.5	3.8	43.0
LAC-100208-A3hr-70	60	73.7	20.2	32.9	
LAC-100208-A3hr-80	60	82.2	46.6		
LAC-100208-B6hr-60	70	60.4	2.1	2.0	12.9
LAC-100208-B6hr-70	70	73.4	20.1	24.0	
LAC-100208-B6hr-80	70	83.0	75.4		
LAC-100208-C12hr-60	80	63.6	3.3	3.2	17.8
LAC-100208-C12hr-70	80	70.0		18.0	
LAC-100208-C12hr-80	80	79.1	14.4		
Molasses		69.8	18.7	64.1	120.0
HP-Settling Sample		72.0	4.2	20.2	120.0

Figure 38

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# **NON-SETTLING HYDROLYZED WHEY PERMEATE CONCENTRATE AND RELATED METHODS AND NUTRITIONAL COMPOSITIONS**

## **RELATED APPLICATION DATA**

This application is a continuation of U.S. patent application Ser. No. 12/729,055, filed Mar. 22, 2010, which claims the priority benefit of U.S. Provisional Patent Application Ser. Nos. 61/162,164, filed Mar. 20, 2009, and 61/162,178, filed Mar. 20, 2009, which are hereby incorporated herein in their entirety by reference.

## **TECHNICAL FIELD**

The present invention relates to whey permeate hydrolysate concentrates for nutritional supplement compositions and foodstuffs that may be used for livestock and humans, and methods of their production and use.

## **BACKGROUND OF THE INVENTION**

Whey comes from the manufacture of cheese. Whey permeate (sometimes also referred to as permeate processed whey) comes from a process of removing at least some of the protein from whey. The whey permeate is usually condensed to remove at least some of the water. A typical condensed whey permeate comprises about 35-45% by weight total solids, of which total solids about 75-80% by weight is lactose.

It is beneficial to produce whey permeate hydrolysate concentrates for use in a wide variety of animal and human foodstuffs and nutritional compositions and supplements. These uses include use of whey permeate hydrolysate concentrates as substitutes for other components of foodstuffs and nutritional compositions.

One of the difficulties in the transport and use of whey permeate hydrolysate concentrates is that the liquid products are subject to sedimentation such that they cannot perform as desirable in a wide variety of industrial and agricultural uses that may require storage or transport over time and temperature profiles where sedimentation occurs, thus preventing their benefits from being realized.

In addition, liquid whey permeate hydrolysate concentrates also may be of such high viscosity that they can be unsuitable for industrial and agricultural uses that involve pumping, conduit transport or pouring.

Accordingly, where it is desired to use liquid whey permeate hydrolysate concentrates in industrial food production, such as in the production of animal feeds or food preparation processes, it is beneficial to be able to provide liquid whey permeate hydrolysate concentrates that have beneficial solids contents, while maintaining sufficiently good viscosity and resistance to sedimentation that they may be pumped, transferred by conduit or poured in industrial settings.

Accordingly, there remains a need for whey permeate hydrolysate concentrates that offer all of the nutritional benefits of hydrolyzed lactose and resultant galactooligosaccharides (GOS), but likewise offer an advantageous collection of concomitant physical properties, such as high solids, as well as suitable viscosity and resistance to sedimentation over typical storage periods and within temperature ranges experienced in various storage and transportation conditions, and in application climates.

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## **SUMMARY OF THE INVENTION**

The present invention includes a method for producing non-settling hydrolyzed whey permeate concentrate, the hydrolyzed whey permeate concentrate produced thereby, and nutritive products containing same or produced therefrom.

The present invention also includes nutritional supplement and additive compositions in liquid or solid form that may be used in a wide variety of human and livestock applications and the like, such as for livestock feed mixture. Also included are methods of preparing the nutritional supplement and additive compositions, as well foodstuffs, using hydrolyzed whey permeates made in accordance with the present invention.

The present invention includes hydrolyzed whey permeate concentrates that may be rendered into a solid form, and which as liquids exhibit improved bulk handling and storage properties, as well as improved flow and non-settling properties, and which can be processed through liquid handling equipment, such as through pumps, conduits and the like.

The characteristics of the non-settling hydrolyzed whey permeate (NHWP) prepared in accordance with this embodiment of the present invention include the ability to concentrate a hydrolyzed whey permeate to a pumpable, pourable, non-settling liquid, most preferably with 75-80% solids.

As to the non-settling parameters of the liquid composition of the present invention, these compositions have a sedimentation rate such that the liquid product may be held at 90 F for at least two weeks with no appreciable sedimentation, preferably up to four weeks and beyond.

Method of Producing a Non-Settling Hydrolyzed Whey Permeate

The present invention includes a method of producing a non-settling hydrolyzed whey permeate with an enzyme, the method comprising the steps: (a) subjecting the whey permeate having an initial solids content in the range of from about 15 to about 25 percent solids to hydrolysis by an enzyme, so as to obtain a whey permeate hydrolysate having a degree of hydrolysis above about 65 percent and preferably between about 65 percent and about 80 percent, and (b) subjecting the whey permeate hydrolysate to evaporation so as to bring the level of solids in the whey permeate hydrolysate to within a range of from about 60 to about 80 percent solids, so as to obtain a whey permeate hydrolysate concentrate whose settling profile is such that there is no detectable settling over two weeks when stored at 90 degrees F., which corresponds to a pellet volume of approx 0.2-0.4 ml as measured in the specified Centrifuge Settling Test.

The parameters of the Centrifuge Settling Test are as follows:

1. Table top centrifuge
2. 1,250 RPM
3. Radius 14 cm.
4. Calculated G force: 244 g
5. Test temperature 75 F
6. Pellet volume measured vs. time.

The present invention include a method of producing a non-settling hydrolyzed whey permeate with an enzyme, the method comprising the steps: (a) maintaining whey permeate having an initial solids content in the range of from about 15 to about 25 percent solids in a reaction vessel at a temperature in the range of from about 70° to about 80° C. for a period in the range of from about 15 to about 45 minutes; (b) cooling the whey permeate to within a temperature range at which the enzyme is reactive; (c) subjecting the whey permeate to hydrolysis by the enzyme at a

temperature in the range of from about 25° to about 50° C. and at a pH in the range of from about 5.0 to about 7.5 for a period of time in the range of from about 3 to about 24 hours, so as to obtain a whey permeate hydrolysate; (i.e., the reaction mixture need only be in the pH and temperature range of any chosen lactase enzyme—e.g. fungal could be as low as pH3, some thermophilic lactases (not yet commercially available) could be as high as 60° C.); (d) subjecting the whey permeate hydrolysate to evaporation so as to bring the level of solids in the whey permeate hydrolysate to within a range of from about 60 to about 80 percent solids, so as to obtain a whey permeate hydrolysate whose settling profile is such that there is no detectable settling over two weeks when stored at 90 deg F.°, which corresponds to a pellet volume of approx 0.2-0.4 ml as measured in the specified Centrifuge Settling Test.

It is preferred that the whey permeate has an initial solids content in the range of from about 18 to about 20 percent solids. The preferred enzyme concentration is in the range of from about 0.08%-0.12% of the reaction mixture for this solids range.

It is also preferred that the hydrolysis by the enzyme is carried out at a temperature in the range of a temperature in the range of from about 25° to about 50° C. and at a pH in the range of from about 5.0 to about 7.5 for a period of time in the range of from about 3 to about 24 hours, most preferably from about 35° to about 40° C., and that the hydrolysis by the enzyme is carried out at a pH in the range of from about 6.5 to about 7.0.

The hydrolysis reaction typically will be carried out for a period of time in the range of from about 4 to about 16 hours, preferably 12-16 hours. Typically, the degree of hydrolysis will be above about 65 percent, and preferably in the range of from about 65 percent to about 80 percent. In addition, under the prescribed enzymatic concentration, the liquid whey permeate hydrolysate condensate will have a galactooligosaccharides (GOS) content in the range of about 3% to 5% by weight.

The evaporation step may be carried out so as to bring the level of solids in the whey permeate hydrolysate condensate to within a range of from about 65 to about 80 percent solids, preferably 70-75 percent solids.

#### Non-Settling Hydrolyzed Whey Permeate

The present invention also includes a liquid whey permeate hydrolysate condensate composition made in accordance with the method of the present invention.

The present invention includes a liquid whey permeate hydrolysate condensate composition comprising a non-settling hydrolyzed whey permeate, wherein the whey permeate hydrolysate has a degree of hydrolysis in the range of from about 65 percent to about 80 percent, contains solids within a range of from about 65 to about 80 percent solids, preferably 70-75 percent solids, and resists settling for at least 2 weeks when maintained at 90 degrees F. The liquid composition also has a viscosity in the range of from about 20 milli-Pascals (or centipoise) at 90 degrees F. to about 120 milli-Pascals (or centipoise) at 5 degrees F. as measured by a Brookfield Viscometer.

#### Method of Producing a Dry Product from Non-Settling Hydrolyzed Whey Permeate

The present invention also includes a method of producing a dried product from a non-settling hydrolyzed whey permeate with an enzyme, the method comprising the steps as described above and further adding a drying agent to the whey permeate hydrolysate so as to obtain a dry product. The drying agent may be any substance appropriate to the

desired nutritional application, and examples are those selected from the group consisting of maltodextrins and starches.

As to the physical characteristics that make the liquid compositions of the present invention beneficial in terms of being able to be pumped and poured, these compositions have a viscosity in the range of from about 90 to about 130 centipoise at 90 F.°.

#### Nutritional Supplements, Components, Food Products and Related Methods

The method of the present invention allows the production of a "milk syrup" liquid which is a pumpable, pourable, non-settling liquid preferably at 75-80% solids and which contains hydrolyzed lactose components and milk minerals.

The present invention also allows for the production of a dry product with same composition as the liquid concentrate produced in accordance with the present invention. This may be done with the aid of the addition of a drying aid, such as maltodextrin, starch or other well known drying aids. The present invention therefore includes methods of producing nutritional supplements, compositions and foodstuffs using the dried form of the liquid product composition of the present invention, the compositions themselves, and methods of their use.

The dry product composition of the present invention may be used in place of a corn syrup solids replacement for ice cream and other food applications. The present invention includes methods of producing nutritional supplements, compositions and foodstuffs using the liquid product composition of the present invention as a corn syrup solids substitute, the compositions themselves, and methods of their use.

The liquid product composition of the present invention may be used as a brown rice syrup replacement in foods products as is known in the art, such as for nutrition/protein bars and the like which offer a reduced glycemic index relative to sucrose or corn syrup solids. Examples of brown rice syrup uses include use as a sweetener, or for making baked goods such cookies, crisps, granola, pies, and puddings, and may be combined with another sweetener such as maple for cakes. Thus, the present invention includes methods of producing nutritional supplements, compositions and foodstuffs using the liquid product composition of the present invention as a brown rice syrup substitute, the compositions themselves, and methods of their use.

The liquid product composition of the present invention also may find beneficial application as a molasses replacement in nutritive compositions and formulations, such as for animal feed applications. Accordingly, the present invention includes methods of producing nutritional supplements, compositions and foodstuffs using the liquid product composition of the present invention, the compositions themselves, and methods of their use.

The liquid product composition of the present invention also may be used as a liquid rumen microorganism stimulant in the same manner as described for a corresponding dry product, as described in U.S. Pat. No. 6,033,689, which is hereby incorporated herein by reference. Accordingly, the present invention includes methods of producing such a liquid rumen microorganism stimulant and methods of its use for stimulating the growth of microorganisms in a ruminant animal by administering to the ruminant animal an effective amount of a liquid composition according to claim 11.

The liquid product composition of the present invention also may be used as a pelleted feed improvement in which

the NHWP acts as a binder in place of those as applied in accordance with known formulations and processes.

The liquid product composition of the present invention also may be applied as an agglomeration aid for fast dispersing dried milk replacement products in a wide variety of forms and for several applications, such as a natural dairy beverage additive in the form of agglomerated natural milk powder as described in U.S. Pat. No. 6,777,014, incorporated herein by reference. The invention thus includes a fast dispersing dried milk replacer product comprising an agglomeration aid comprising a liquid composition according to the present invention.

The liquid product composition of the present invention also may be used in a protein and carbohydrate encapsulated fat composition comprising an encapsulant component, wherein the encapsulant component encapsulant component comprising a liquid composition according to the present invention. The invention therefore includes a protein and carbohydrate encapsulated fat protein and carbohydrate encapsulated fat made using a liquid composition according to the present invention. Such compositions may be used as calf milk replacers, and the invention also includes a method of providing such nutrition to calves.

Although not limited to the theory of the invention, it is believed these improved properties are a result of the processing conditions used to enzymatically treat the whey permeate and concentrating the whey permeate condensate.

The methods of the present invention may be practiced using lactose as an alternative starting material as also described in co-pending patent application entitled NON-SETTLING GALACTOOLIGOSACCHARIDE-RICH LIQUID CONCENTRATE AND RELATED METHODS AND NUTRITIONAL COMPOSITIONS filed Mar. 22, 2010, hereby incorporated herein by reference.

#### BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a schematic flow diagram of a reaction process in accordance with one embodiment of the present invention;

FIG. 2 is a graph of sugars versus reaction time showing a typical reaction profile for the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 3 is a graph of sugars versus reaction time showing a typical reaction profile for the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 4 is a graph of sugars versus reaction time showing a typical reaction profile for the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 5 is a graph of lactose versus reaction time showing a typical reaction profile for the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 6 is a graph of galactooligosaccharides (GOS) versus reaction time showing a typical reaction profile for the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 7 is a photograph showing the physical properties of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 8 is a table showing the measurements of chemical properties from HPLC data taken from whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 9 is a table showing the details of a process for producing a molasses substitute material in the form of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 10 is a table showing a trial process for demonstrating the effect of hydrolysis on permeate solids in the production of whey permeate hydrolysate concentrates in accordance with one embodiment of the present invention.

FIG. 11 is a table showing the details of a process and experimental design for producing whey permeate hydrolysate concentrates in accordance with one embodiment of the present invention.

FIG. 12 is a table showing the data from several experiments for demonstrating the physical properties of whey permeate hydrolysate in accordance with one embodiment of the present invention, and includes a table showing a typical sugar test sample preparation from several experiments for demonstrating the chemical and physical properties of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 13 is a table showing the data from several experiments involving varying enzyme concentrations, for demonstrating the physical properties of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 14 is a graph of sugars versus reaction time showing a typical reaction profile for the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 15 is a graph of sugars versus reaction time showing a typical reaction profile for the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 16 is a graph of sugars versus reaction time showing a typical reaction profile for the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 17 is a table showing the data from several experiments involving varying reaction times and showing physical properties of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 18 is a table showing the data from several experiments involving varying reaction times and showing physical properties of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 19 is a table showing the data from several experiments involving varying reaction times and showing physical properties of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 20 is a graph of sugars versus reaction time showing a typical reaction profile for the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 21 is a graph of sugars versus reaction time showing a typical reaction profile for the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 22 is a graph of sugars versus reaction time showing a typical reaction profile for the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 23 is a graph of lactose versus reaction time showing a typical reaction profile for the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 24 is a graph of GOS versus reaction time showing a typical reaction profile for the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 25 is a table showing a trial process for demonstrating the effect of hydrolysis on permeate solids in the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 26 is a graph of lactose hydrolysis versus time for various enzyme concentrations for the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 27 is a graph of percent lactose hydrolysis versus time for various enzyme concentrations for the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 28 is a table showing the data from several experiments involving varying reaction times and showing physical properties of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 29 is a graph of lactose hydrolysis versus time for various enzyme concentrations for the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 30 is a graph of enzymatic hydrolysis in the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 31 is a graph of enzymatic hydrolysis in the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 32 is a graph of enzymatic hydrolysis in the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 33 is a graph of enzymatic hydrolysis in the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 34 is a graph of enzymatic hydrolysis in the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 35 is a graph of viscosity versus solids in the production of whey permeate hydrolysate concentrate in accordance with one embodiment of the present invention.

FIG. 36 is a graph of enzymatic hydrolysis in the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 37 is a graph of enzymatic hydrolysis in the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 38 is a table showing the data from several experiments detailing the settling profile and showing physical properties of whey permeate hydrolysate concentrate in accordance with one embodiment of the present invention.

#### DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

In accordance with the foregoing summary of the invention, the following presents a detailed description of the preferred embodiments, which are considered to be the best mode thereof.

The preferred method and compositions described herein are not intended to be exhaustive or to limit the invention to the precise forms disclosed. They are chosen and described to explain the principles of the invention and the application of the method to practical uses so that others skilled in the art may practice the invention.

Example 1 of the Manufacturing Process of the Present Invention

As a preferred but non-limiting example of the method by which compositions of the present invention may be made, the following steps may be followed:

FIG. 1 is a schematic flow diagram of a reaction process, and is representative of the process to manufacture a non-settling hydrolyzed whey permeate (NHWP) in accordance with one embodiment of the present invention.

The process steps for manufacture of NHWP include:

1. Add whey permeate or lactose to hydrolysis vessel (15-25% solids, preferably 18-20%)
2. Heat whey permeate or lactose solution to 70 to 80° C. (preferably 75° C.) for 15 to 45 min (preferably 30 min)
3. Cool to specified reaction temperature of enzyme used (different for different enzyme sources)
4. Hydrate enzyme in process water at reaction temperature in separate vessel and transfer to hydrolysis vessel to start hydrolysis
5. Carry out hydrolysis at optimal temperature (25 to 50° C.—preferably 35-40° C.) and pH optimal (5.0 to 7.5—preferably 6.5-7.0) for 3 to 24 hours (preferably 12 to 16 hours)
6. After hydrolysis has reached desired level transfer to evaporator and evaporate to 60 to 80% solids (preferably 75-80% solids)
7. When desired level of solids is reached transfer to product storage vessel

Detailed lab and plant protocols along with HPLC sugar profiles are attached as the Figures hereto.

As can be appreciated from FIG. 1, this schematic shows a flow diagram of a reaction process in accordance with one embodiment of the present invention. The whey permeate is preferably held in a holding tank with available stirring as shown. Likewise, the enzyme, such as Novo® Lactase (commercially available from Novozymes of Bagsvaerd, Denmark) or Validase® (commercially available from Valley Research of South Bend, Ind.), is held in a holding tank with available stirring. The whey permeate and enzyme are conducted to a hydrolysis reaction tank where hydrolysis takes place under the above described conditions. The resultant hydrolysate is then conducted to an evaporator where it is concentrated to the solids level described herein. The resultant hydrolysate concentrate may then be further conducted to a product storage tank or through conduits for further processing or packaging as required by the desired application.

FIGS. 2-4 are graphs of sugars versus reaction time showing a typical reaction profile for the production of whey permeate hydrolysate in accordance with one embodiment of the present invention, showing the results for various respective Novo Lactase concentrations.

FIG. 5 is a graph of lactose versus reaction time showing a typical reaction profile for the production of whey permeate hydrolysate in accordance with one embodiment of the present invention, showing the results for various respective Novo Lactase concentrations.

FIG. 6 is a graph of galactooligosaccharides (GOS) versus reaction time showing a typical reaction profile for the production of whey permeate hydrolysate in accordance with one embodiment of the present invention, showing the results for various respective Novo Lactase concentrations.

FIG. 7 is a photograph showing the physical properties of whey permeate hydrolysate in accordance with one embodiment of the present invention, having 80% solids and after 12 hours hydrolysis at pH 6.5 with various respective Novo Lactase concentrations.



FIG. 8 is a table showing the measurements of chemical properties from HPLC data taken from whey permeate hydrolysate in the processes described herein.

FIG. 9 is a table showing the details of a process for producing a molasses substitute material in the form of whey permeate hydrolysate concentrate as described herein.

FIG. 10 is a table showing a trial process for demonstrating the effect of hydrolysis on permeate solids in the production of whey permeate hydrolysate concentrates in accordance with one embodiment of the present invention.

FIG. 11 is a table showing the details of a process and experimental design for producing whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 12 is a table showing the data from several experiments for demonstrating the physical properties of whey permeate hydrolysate in accordance with one embodiment of the present invention, and includes a table showing a typical sugar test sample preparation from several experiments for demonstrating the chemical and physical properties of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 13 is a table showing the data from several experiments involving varying enzyme concentrations, for demonstrating the physical properties of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIGS. 14, 15 and 16 are graphs of sugars versus reaction time showing a typical reaction profile for the production of whey permeate hydrolysate in accordance with several embodiments of the present invention. These graphs elucidate the properties that give rise to the preferred embodiment of the invention.

FIGS. 17, 18 and 19 are tables showing the data from several experiments involving varying reaction times and showing physical properties of whey permeate hydrolysate in accordance with several embodiments of the present invention, and serves to show the variations in the preparation of whey permeate hydrolysate in accordance with the invention.

FIGS. 20, 21 and 22 are graphs of sugars versus reaction time showing a typical reaction profile for the production of whey permeate hydrolysate with differing enzyme concentrations, in accordance with several embodiments of the present invention.

FIG. 23 is a graph of lactose versus reaction time showing a typical reaction profile for the production of whey permeate hydrolysate in accordance with several embodiments of the present invention.

FIG. 24 is a graph of GOS versus reaction time showing a typical reaction profile for the production of whey permeate hydrolysate in accordance several embodiments of the present invention.

FIG. 25 is a table showing a trial process for demonstrating the effect of hydrolysis on permeate solids in the production of whey permeate hydrolysate in accordance with several embodiments of the present invention.

FIGS. 26 and 27 are graphs of lactose hydrolysis versus time for various enzyme concentrations for the production of whey permeate hydrolysate in accordance with several embodiments of the present invention.

FIG. 28 is a table showing the data from several experiments involving varying reaction times and showing physical properties of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIG. 29 is a graph of lactose hydrolysis versus time for various enzyme concentrations for the production of whey permeate hydrolysate in accordance with one embodiment of the present invention.

FIGS. 30-34 are graph of enzymatic hydrolysis in the production of whey permeate hydrolysate in accordance with several embodiments of the present invention.

FIG. 35 is a graph of viscosity versus solids in the production of whey permeate hydrolysate concentrate in accordance with several embodiments of the present invention. This graph shows the viscosity levels that may be achieved in accordance with the present invention.

FIG. 36 is a graph of enzymatic hydrolysis in the production of whey permeate hydrolysate in accordance with several embodiments of the present invention.

FIG. 37 is a graph of enzymatic hydrolysis in the production of whey permeate hydrolysate in accordance with several embodiments of the present invention.

FIG. 38 is a table showing the data from several experiments detailing the settling profile and showing physical properties of whey permeate hydrolysate concentrate in accordance with several embodiments of the present invention. This graph shows the beneficial settling profiles that may be achieved in accordance with the present invention.

The characteristics of the NHWP prepared in accordance with this embodiment of the present invention include the ability to concentrate a hydrolyzed whey permeate to a pumpable, pourable, non-settling liquid, most preferably with 70-80% solids.

The method of the present invention allows the production of a "milk syrup" liquid which is a pumpable, pourable, non-settling liquid preferably at 75-80% solids and which contains hydrolyzed lactose components and milk minerals.

The present invention also allows for the production of a dry product with same composition as the liquid concentrate produced in accordance with the present invention. This may be done with the aid of the addition of a drying aid, such as maltodextrin, starch or other well known drying aids. The present invention therefore includes methods of producing nutritional supplements, compositions and foodstuffs using the dried form of the liquid product composition of the present invention, the compositions themselves, and methods of their use.

The dry product composition of the present invention may be used in place of a corn syrup solids replacement for ice cream and other food applications. The present invention includes methods of producing nutritional supplements, compositions and foodstuffs using the liquid product composition of the present invention as a corn syrup solids substitute, the compositions themselves, and methods of their use.

The liquid product composition of the present invention may be used as a brown rice syrup replacement in foods products as is known in the art, such as for nutrition/protein bars and the like which offer a reduced glycemic index relative to sucrose or corn syrup solids. Examples of brown rice syrup uses include use as a sweetener, or for making baked goods such cookies, crisps, granola, pies, and puddings, and may be combined with another sweetener such as maple for cakes. Thus, the present invention includes methods of producing nutritional supplements, compositions and foodstuffs using the liquid product composition of the present invention as a brown rice syrup substitute, the compositions themselves, and methods of their use.

The liquid product composition of the present invention also may find beneficial application as a molasses replacement in nutritive compositions and formulations, such as for

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animal feed applications. Accordingly, the present invention includes methods of producing nutritional supplements, compositions and foodstuffs using the liquid product composition of the present invention, the compositions themselves, and methods of their use.

The liquid product composition of the present invention also may be used as a liquid rumen microorganism stimulant in the same manner as described for a corresponding dry product, as described in U.S. Pat. No. 6,033,689, which is hereby incorporated herein by reference. Accordingly, the present invention includes methods of producing such a liquid rumen microorganism stimulant and methods of its use.

The liquid product composition of the present invention also may be used as a pelleted feed improvement in which the NHWP acts as a binder.

The liquid product composition of the present invention also may be applied as an agglomeration aid for fast dispersing dried milk replacement products in a wide variety of forms and for several applications.

While specific formulations and process steps are discussed, it should be understood that this is done for illustrative purposes only. A person skilled in the relevant art will recognize that other process and composition variations can be used without departing from the spirit and scope of the invention. It will be apparent to a person skilled in the relevant art that this invention can also be employed in a variety of other applications.

What is claimed is:

1. A method of producing a non-settling hydrolyzed whey permeate with an enzyme, the method comprising the steps:
  - subjecting the whey permeate having an initial solids content in the range of from about 15 to about 25

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percent solids to hydrolysis by an enzyme, so as to obtain a whey permeate hydrolysate having a degree of hydrolysis above about 65 percent; and

subjecting the whey permeate hydrolysate to evaporation so as to bring the level of solids in the resulting whey permeate hydrolysate concentrate to within a range of from about 60 to about 80 percent solids, so as to obtain a whey permeate hydrolysate concentrate whose settling profile is such that there is no detectable settling over two weeks when stored at 90° F.

2. A method according to claim 1 wherein the whey permeate has an initial solids content in the range of from about 18 to about 20 percent solids.

3. A method according to claim 1 wherein the hydrolysis by the enzyme is carried out for sufficient time to bring about a degree of hydrolysis between about 65 percent and about 80 percent.

4. A method according to claim 1 wherein the evaporation is carried out so as to bring the level of solids in the whey permeate hydrolysate to within a range of from about 70 to about 75 percent solids.

5. A method according to claim 1 wherein the resulting whey permeate hydrolysate concentrate has a viscosity in the range of 90 to 120 centipoise at 90° F.

6. A method according to claim 1 wherein the resulting whey permeate hydrolysate concentrate has a galactooligosaccharides (GOS) content in the range of about 3% to 5% by weight.

7. A method according to claim 1 further comprising adding a drying agent to the whey permeate hydrolysate.

8. The method of claim 7 wherein the drying agent comprises a maltodextrin or a starch.

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